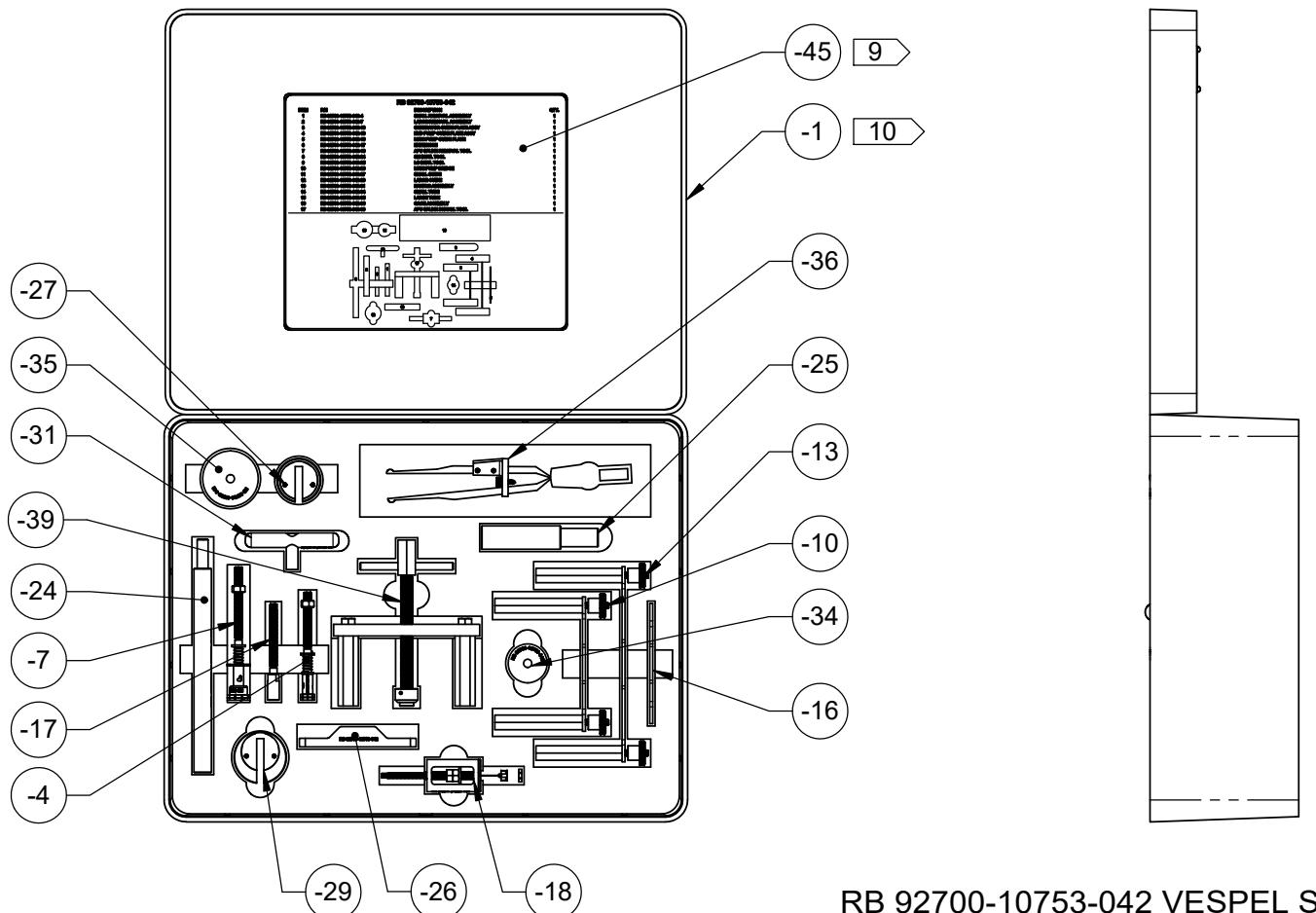


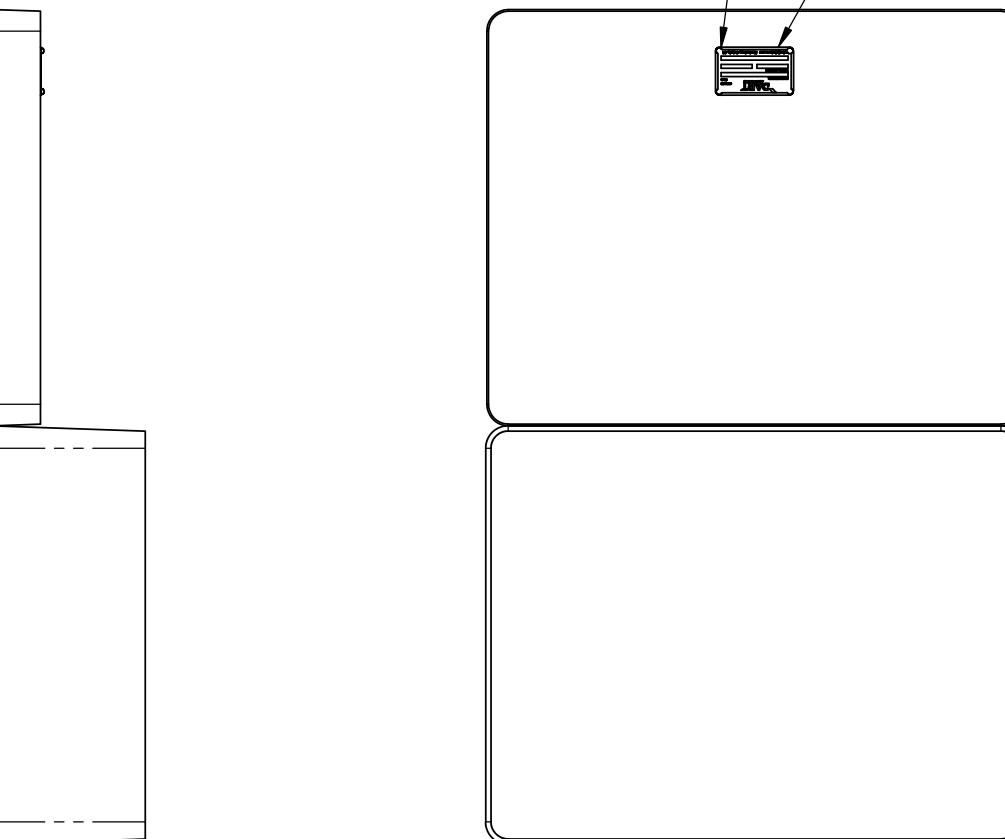
ITEM #	QTY	PART #	PART TITLE			REV.	DESCRIPTION	ECN #	BY
-1	1	RB 92700-10753-042-1	PACKAGING ASSY			A	NEW ISSUE	18-621	VM
-4	1	RB 92700-10753-042-4	SMALL REMOVAL ASSEMBLY			B	UPDATED DOWEL PIN FOR P/N - 4 AND -7, UPDATED -8 DIM WAS 1.014 IS 0.900, UPDATED -24 DIA WAS 0.450 IS 0.466, P/N -18 UPDATED MATERIAL DETAIL FOR ITEM 62, ADDED NOTE 11 TO P/N -36, P/N -39 UPDATED MATERIAL FOR ITEM 70.	ECR 182	SAD
-7	1	RB 92700-10753-042-7	LARGE REMOVAL ASSEMBLY						
-10	1	RB 92700-10753-042-10	GENERATOR GUIDE PLATE ASSY						
-13	1	RB 92700-10753-042-13	HYD PUMP GUIDE PLATE ASSY						
-16	1	RB 92700-10753-042-16	LUBE PUMP GUIDE PLATE						
-17	1	RB 92700-10753-042-17	EXTENSION						
-18	1	RB 92700-10753-042-18	APU SPLINE REMOVAL TOOL						
-24	1	RB 92700-10753-042-24	SM INSTL TOOL						
-25	1	RB 92700-10753-042-25	LG INSTL TOOL						
-26	1	RB 92700-10753-042-26	LUBE PUMP BRIDGE						
-27	1	RB 92700-10753-042-27	SMALL GUIDE						
-29	1	RB 92700-10753-042-29	LARGE GUIDE						
-31	1	RB 92700-10753-042-31	HANDLE ASSEMBLY						
-34	1	RB 92700-10753-042-34	SMALL TUBE						
-35	1	RB 92700-10753-042-35	LARGE TUBE						
-36	1	RB 92700-10753-042-36	GAGE ASSEMBLY						
-39	1	RB 92700-10753-042-39	APU SPLINE INSTALL TOOL						
-45	1	RB 92700-10753-042-45	POSITION PLACARD						
46	1	RB41011	DART PLACARD						
47	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.						



RB 92700-10753-042 VESPEL SPLINE KIT

NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 $X.XX = +/- 0.01" / +/- 0.5"$
 $X.XXX = +/- 0.005" / +/- 0.1"$
 $X.XXXX = +/- 0.0005" / +/- 0.05"$

- PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) BREAK SHARP EDGES: N/A
 7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED
 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
 9) HOT GLUE THE PLASTIC PLACARD ONTO THE TOP FOAM
 10) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE



DESIGN	VM	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	TOOL PART #	REV. B
MFG. APPR.	DD	RB 92700-10753-042	SHEET 1 OF 46
APPROVED	SAD	TITLE	SCALE
		VESPEL SPLINE KIT	NTS
DATE 7/5/2021		COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-2	1	RB 92700-10753-042-2	BOTTOM FOAM
-3	1	RB 92700-10753-042-3	TOP FOAM
48	1	PELICAN #APP-1600-E	PELICAN CASE 1600

D

D

C

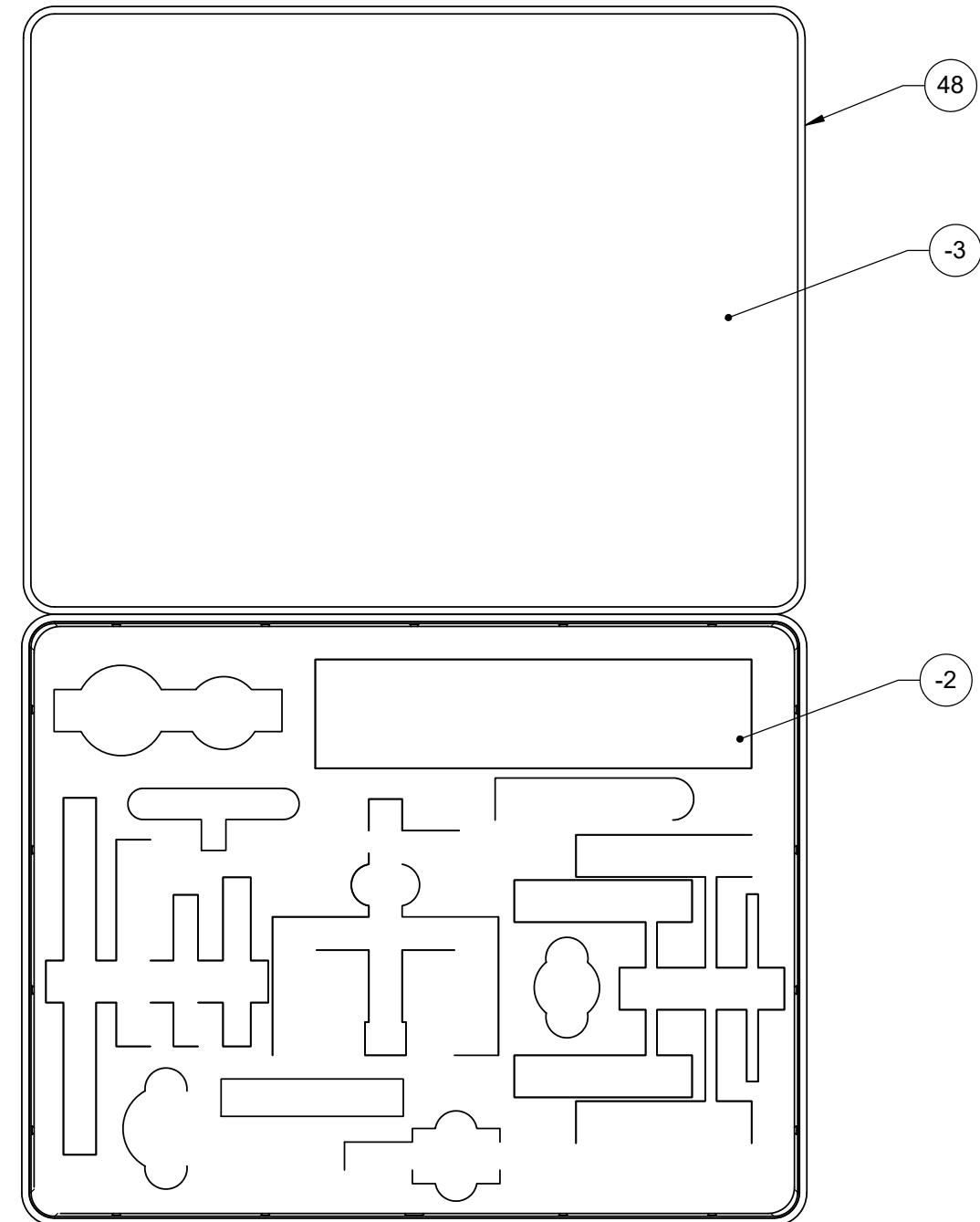
C

B

B

A

A



- NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°

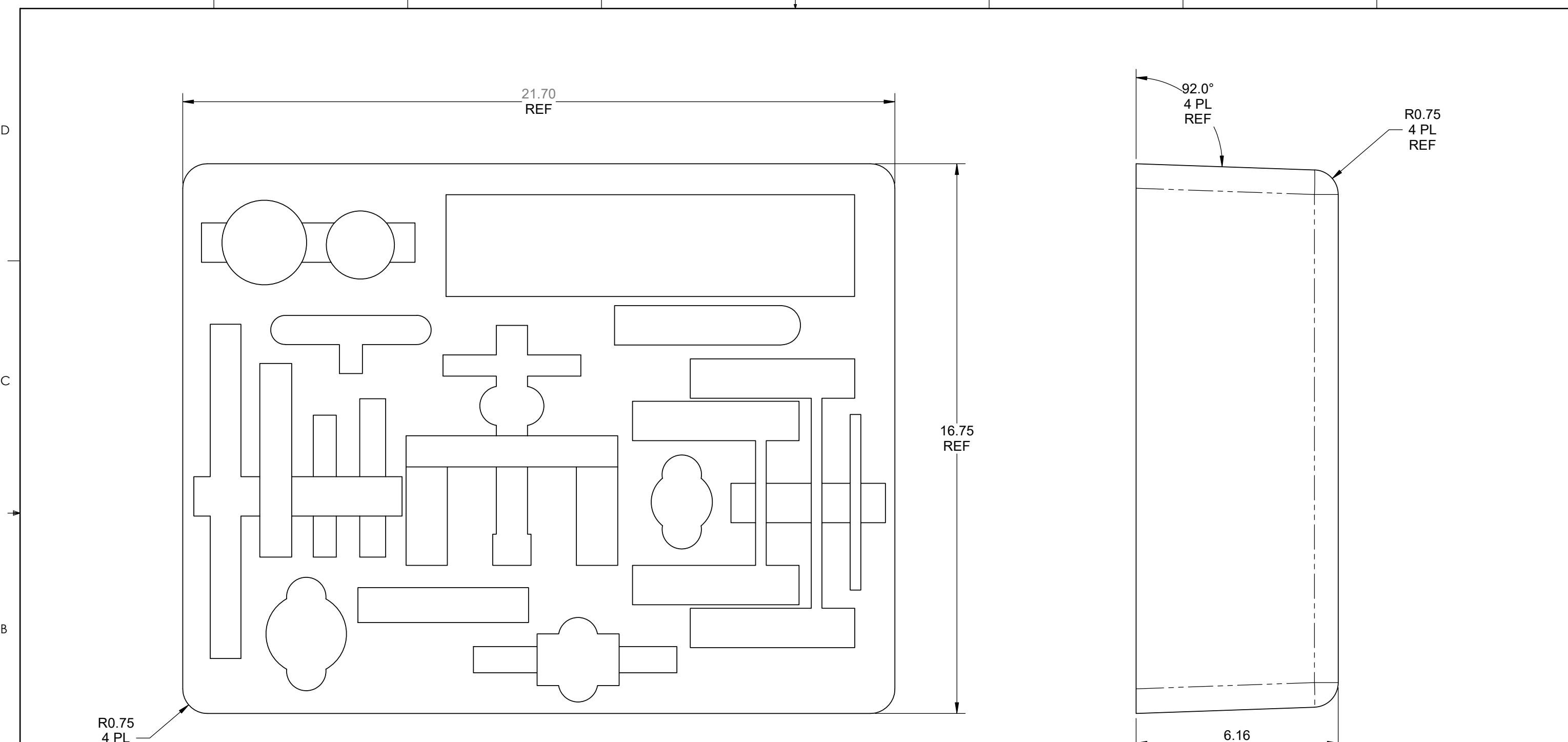
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) BREAK SHARP EDGES: N/A
 7) IDENTIFICATION: N/A

RB 92700-10753-042-1 PACKAGING ASSY

DESIGN	VM	DART AEROSPACE LTD			
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA			
CHECKED	RF	TOOL PART #			
MFG. APPR.	DD	REV. B			
APPROVED	SAD	RB 92700-10753-042			
DATE 7/5/2021		SHEET 2 OF 46			
TITLE VESPEL SPLINE KIT		SCALE NTS			
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NOTES:

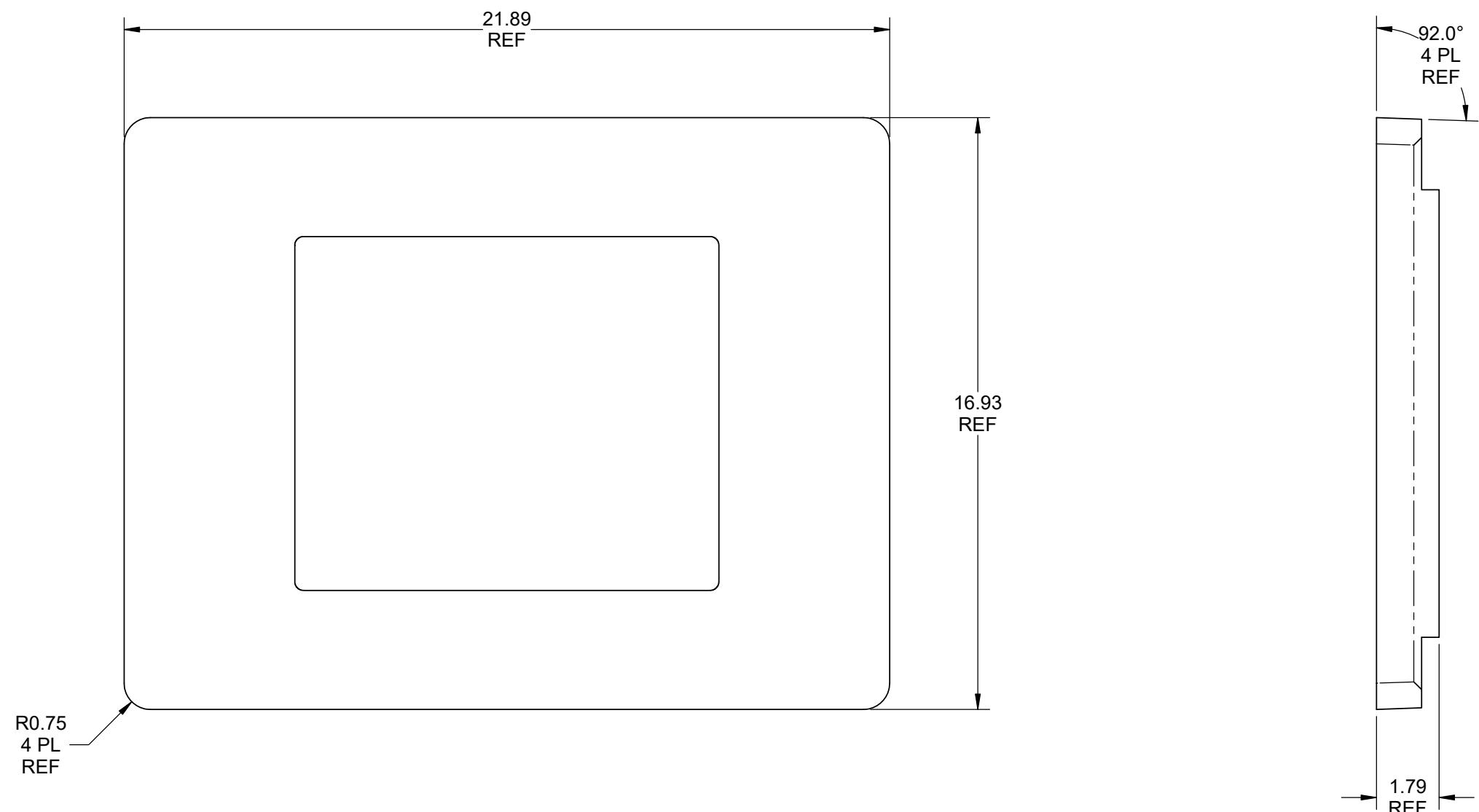
- 1) MATERIAL: BLACK ETHAFOAM 220
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 $X.XX = +/- 0.01" / +/- 0.5°$
 $X.XXX = +/- 0.005" / +/- 0.1°$
 $X.XXXX = +/- 0.0005" / +/- 0.05°$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB 92700-10753-042-2 REV B.STEP

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	TOOL PART #	
MFG. APPR.	DD	REV. B	
APPROVED	SAD	RB 92700-10753-042	
DATE 7/5/2021		SHEET 3 OF 46	NTS
TITLE VESPEL SPLINE KIT		SCALE	
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8 7 6 5 4 3 2 1

D

D



RB 92700-10753-042-3 TOP FOAM

8

NOTES:

- 1) MATERIAL: BLACK ETHAFOAM 220
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

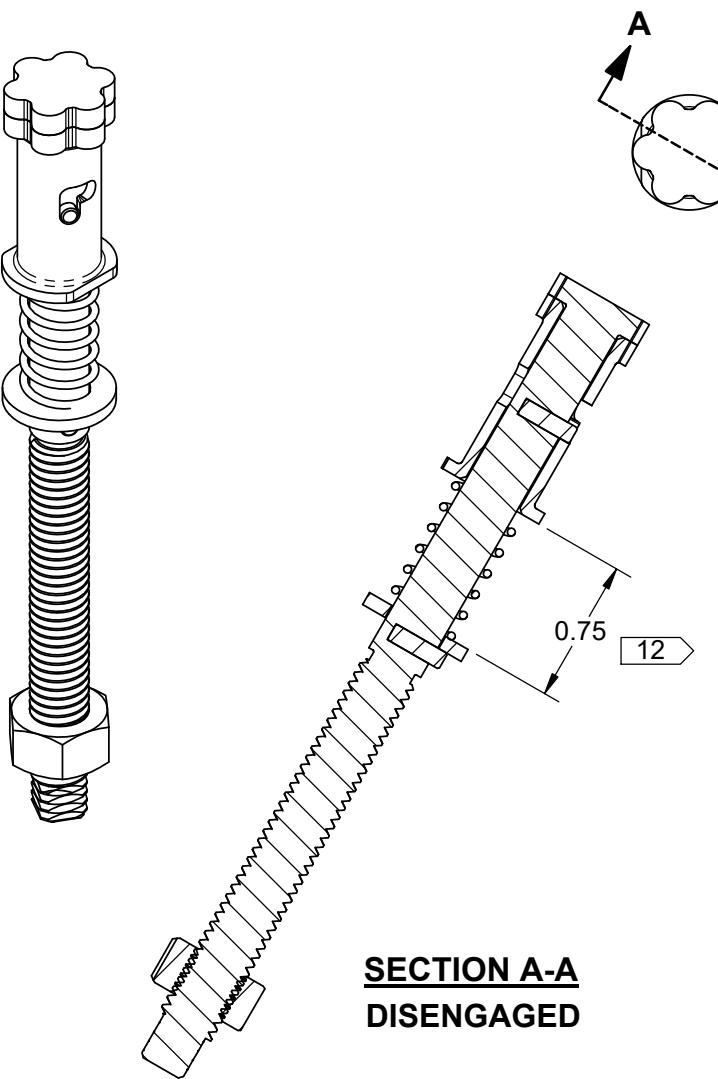
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB 92700-10753-042-3 REV B.STEP

DESIGN	VM	DART AEROSPACE LTD			
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA			
CHECKED	RF	TOOL PART #			
MFG. APPR.	DD	REV. B			
APPROVED	SAD	RB 92700-10753-042			
TITLE		SHEET 4 OF 46			
VESPEL SPLINE KIT		NTS			
DATE 7/5/2021		SCALE			
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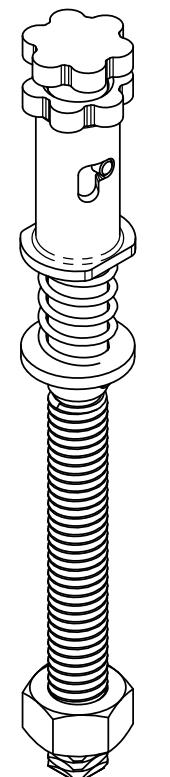
8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-5	1	RB 92700-10753-042-5	COMPRESSION SLEEVE
-6	1	RB 92700-10753-042-6	PIN
49	1	TRAKAR#C1067-107-0191 OR EQUIV	SPRING
50	2	McMaster#98381A435 OR EQUIV	STEEL DOWEL PIN 3/32" DIA. X 5/16" LG.
51	1	McMaster#91922A305 OR EQUIV	STEEL FLAT WASHER FOR 5/16" SCREW 0.593" OD X 0.324" ID.
52	1	McMaster#94895A030 OR EQUIV	STEEL HEX NUT 5/16"-18

D



**SECTION A-A
DISENGAGED**



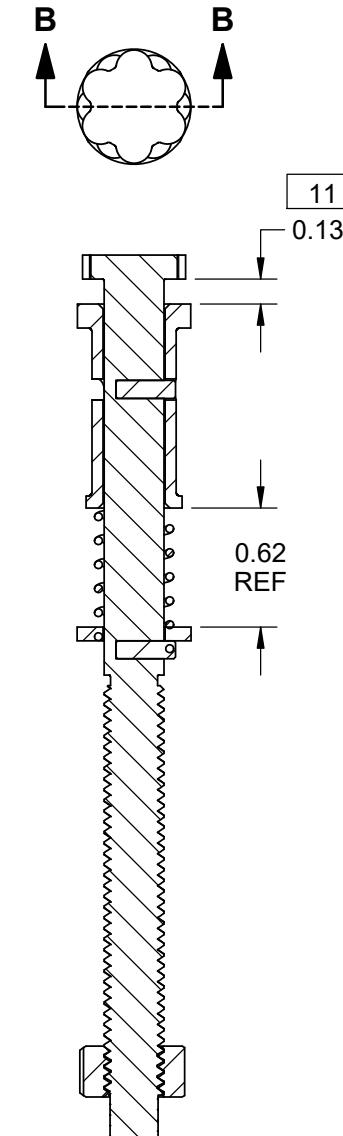
RB 92700-10753-042-4 SMALL REMOVAL ASSEMBLY

13

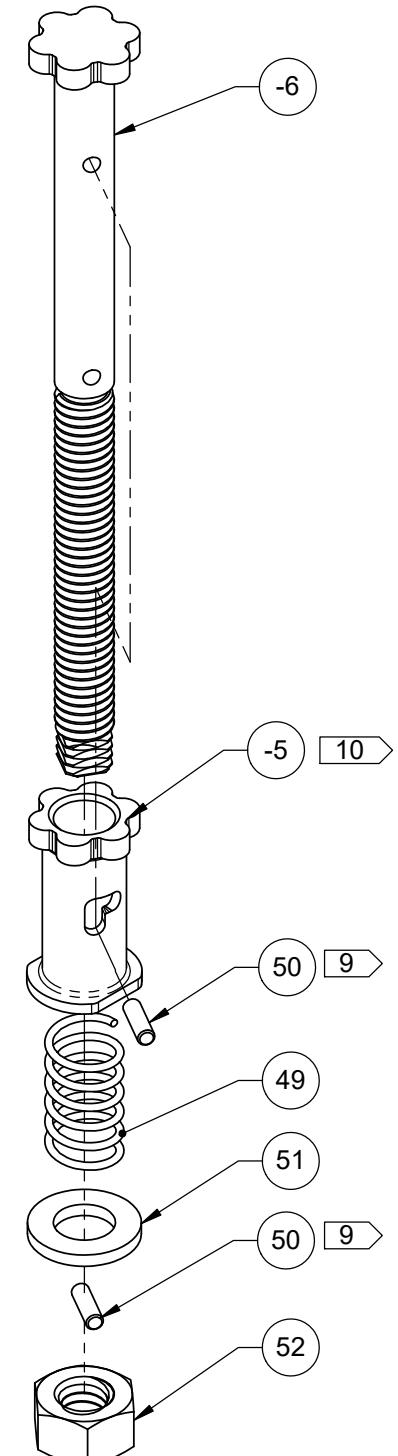
- NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°

5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) BREAK SHARP EDGES: N/A
 7) IDENTIFICATION: N/A
 8) ASSEMBLE AS SHOWN

- 9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 50 DOWEL PIN WITH ITEM -6 AND REMOVE EXCESS
 10) ITEM -5 MUST MOVE FREELY
 11) MUST HAVE THIS DIMENSION WHEN THE TOOL IS ENGAGED AND THE TEETH ARE UNALIGNED
 12) MUST HAVE THIS DIMENSION WHEN THE TOOL IS NOT ENGAGED AND THE THEETH ARE ALIGNED
 13) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG3

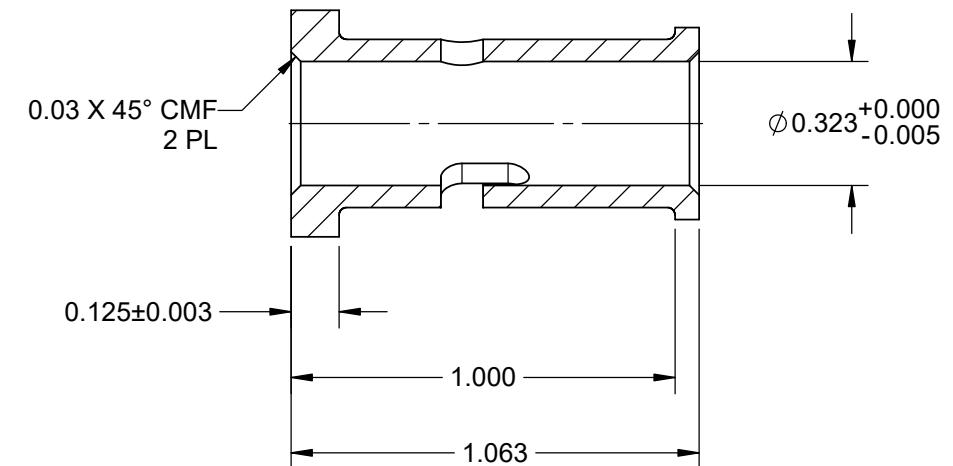
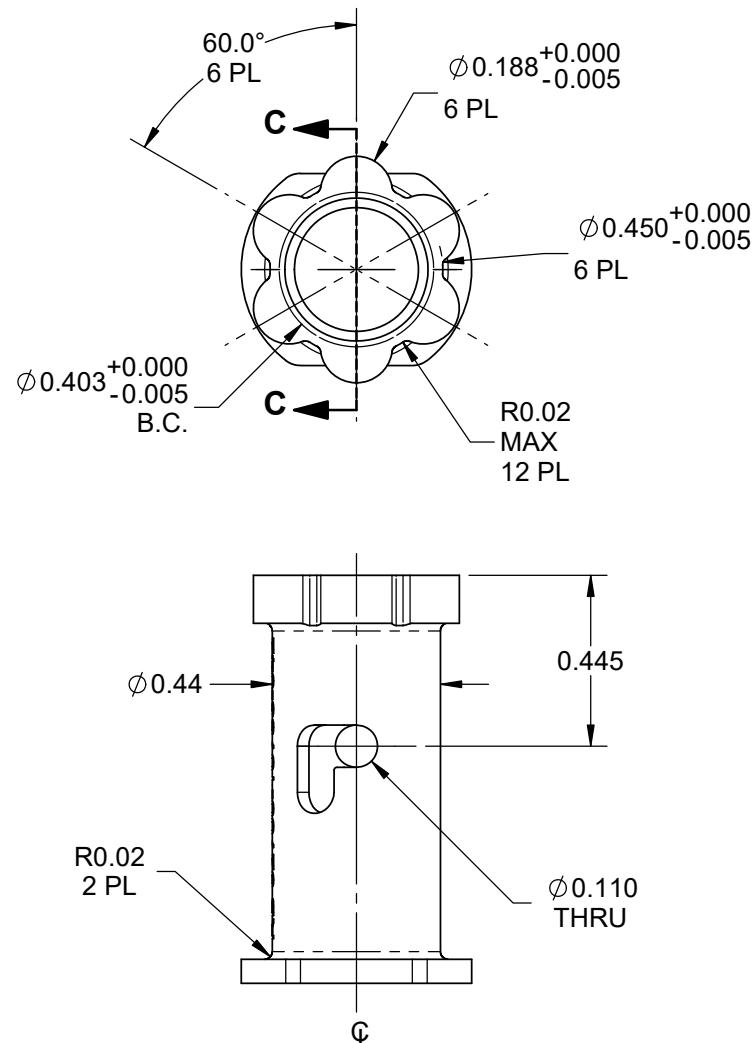
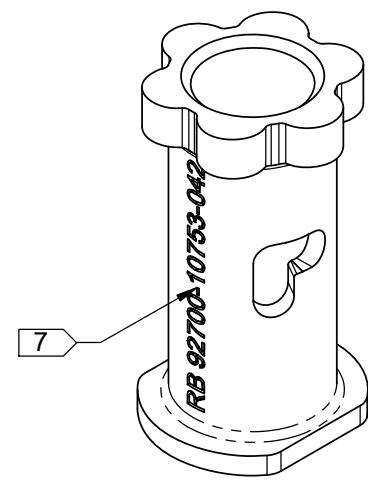


**SECTION B-B
ENGAGED**



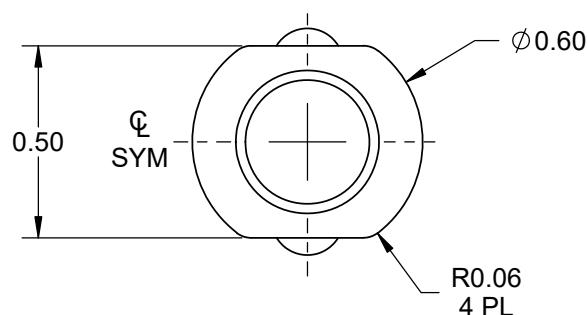
DESIGN	VM	DART AEROSPACE LTD			
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA			
CHECKED	RF	TOOL PART #			
MFG. APPR.	DD	REV. B			
APPROVED	SAD	RB 92700-10753-042			
DATE 7/5/2021		SHEET 5 OF 46			
TITLE VESPEL SPLINE KIT		SCALE NTS			
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8 7 6 5 4 3 2 1



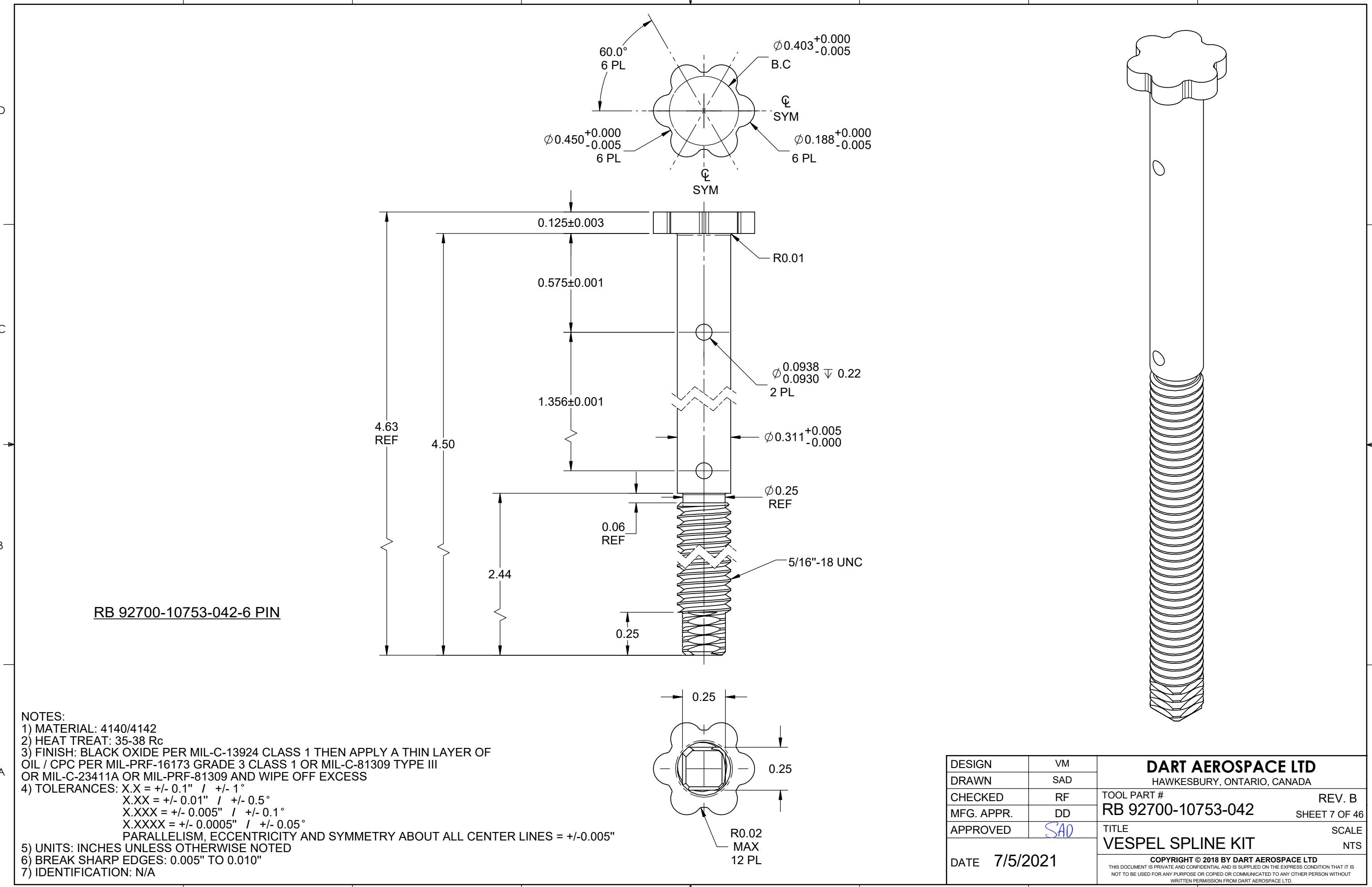
RB 92700-10753-042-5 COMPRESSION SLEEVE

8



- NOTES:
- 1) MATERIAL: 4140/4142
 - 2) HEAT TREAT: 35-38 Rc
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN
 - 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RB 92700-10753-042-5 REV B.STEP

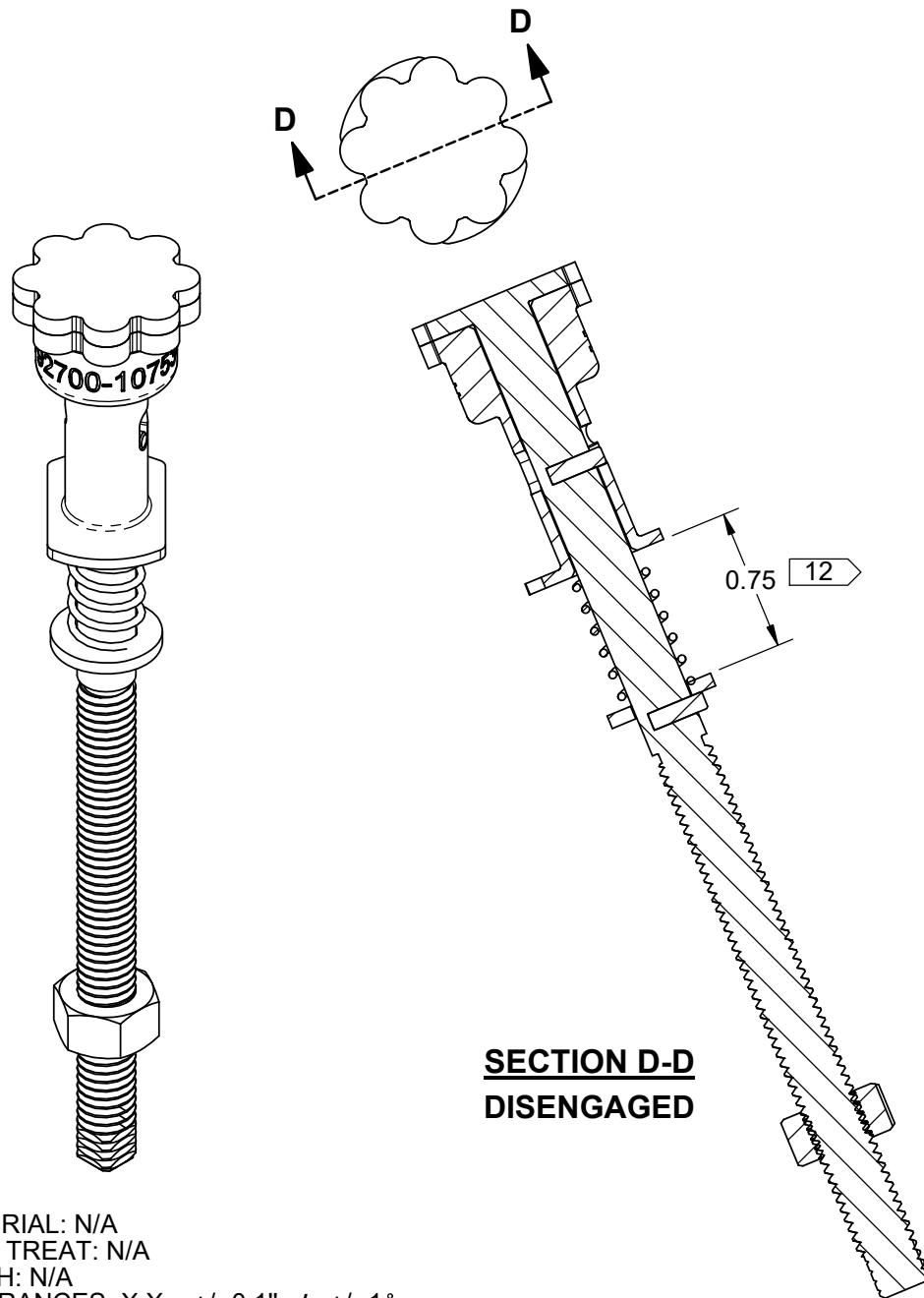
DESIGN	VM	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	TOOL PART #
MFG. APPR.	DD	REV. B
APPROVED	SAD	RB 92700-10753-042
		SHEET 6 OF 46
		TITLE
		VESPEL SPLINE KIT
		SCALE
		NTS
DATE	7/5/2021	COPYRIGHT © 2018 BY DART AEROSPACE LTD
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8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-8	1	RB 92700-10753-042-8	PIN
-9	1	RB 92700-10753-042-9	COMPRESSION SLEEVE
53	1	TRAKAR#C1067-107-0191 OR EQUIV	SPRING
54	1	McMaster#91922A305 OR EQUIV	STEEL FLAT WASHER FOR 5/16" SCREW 0.593" OD x 0.324" ID.
55	2	McMaster#98381A435 OR EQUIV	STEEL DOWEL PIN 3/32" DIA. x 5/16" LG.
56	1	McMaster#94895A030 OR EQUIV	STEEL HEX NUT 5/16"-18

D



NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°

5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) BREAK SHARP EDGES: N/A
 7) IDENTIFICATION: N/A
 8) ASSEMBLE AS SHOWN
 9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEMS 55 DOWEL PIN WITH ITEM -8 AND REMOVE EXCESS

10) ITEM -9 MUST MOVE FREELY

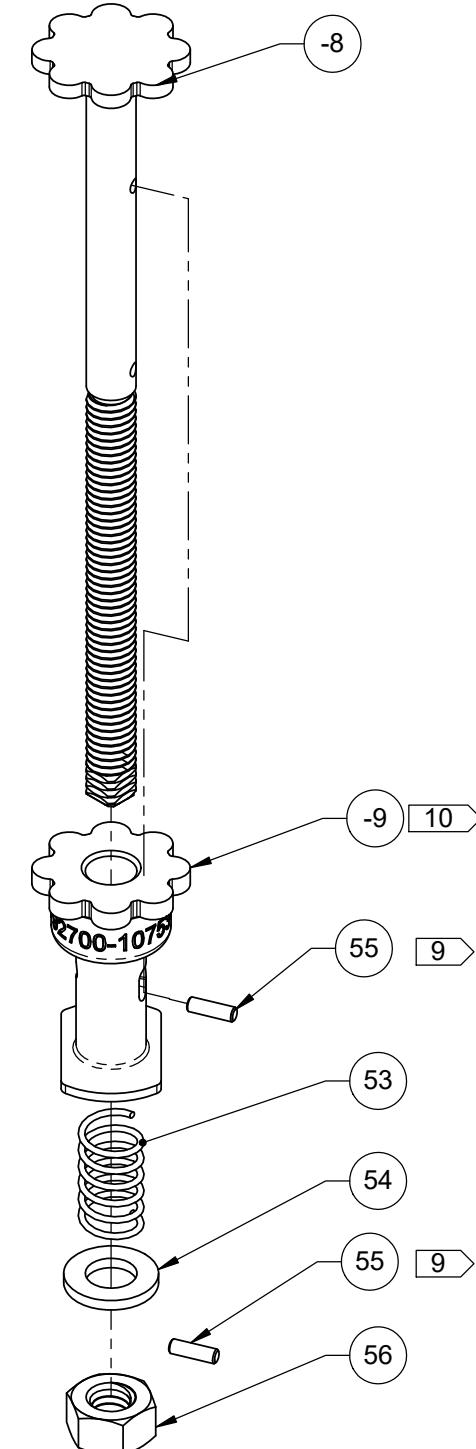
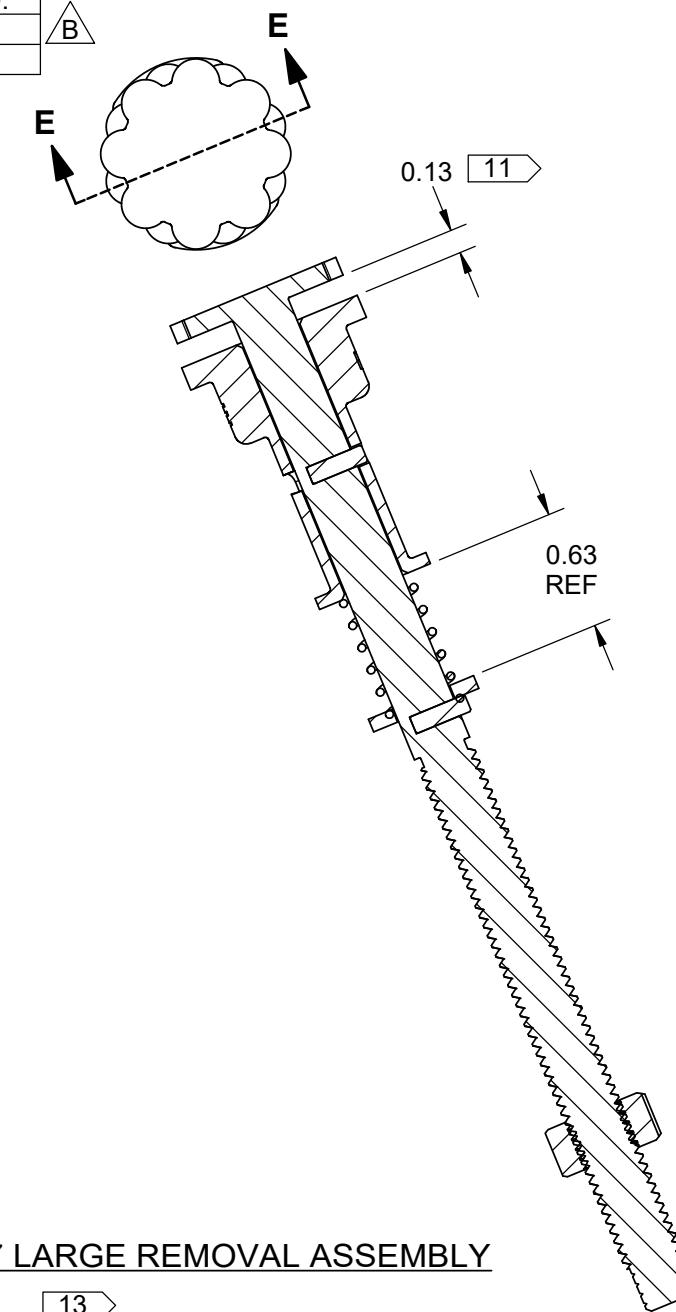
11) MUST HAVE THIS DIMENSION WHEN THE TOOL IS ENGAGED AND THE TEETH ARE UNALIGNED

12) MUST HAVE THIS DIMENSION WHEN THE TOOL IS NOT ENGAGED AND THE THEETH ARE ALIGNED

13) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

RB 92700-10753-042-7 LARGE REMOVAL ASSEMBLY

13



DESIGN	VM	DART AEROSPACE LTD			
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA			
CHECKED	RF	TOOL PART #			
MFG. APPR.	DD	REV. B			
APPROVED	SAD	RB 92700-10753-042			
DATE 7/5/2021		SHEET 8 OF 46			
TITLE VESPEL SPLINE KIT		SCALE NTS			
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8 7 6 5 4 3 2 1

D

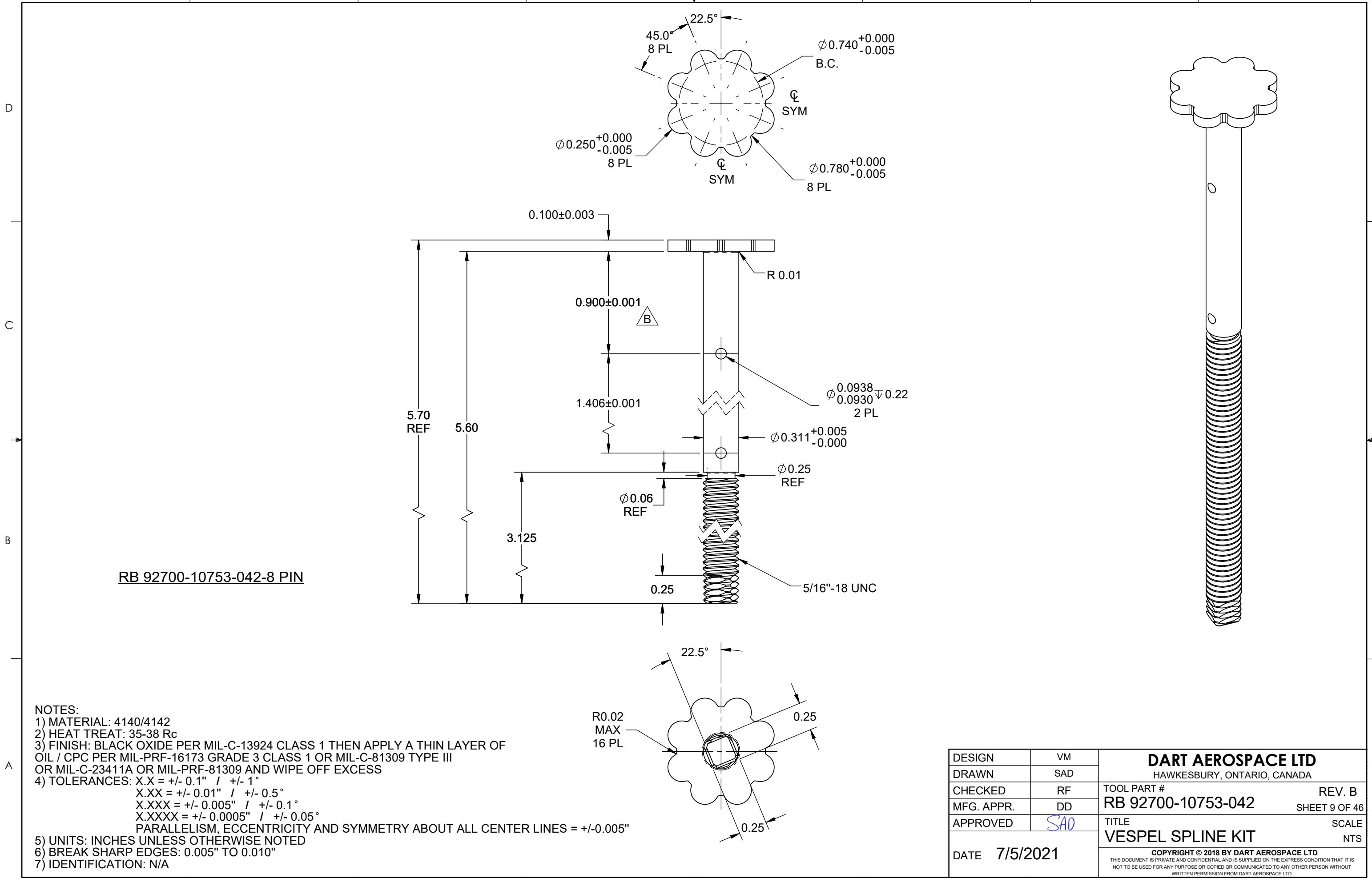
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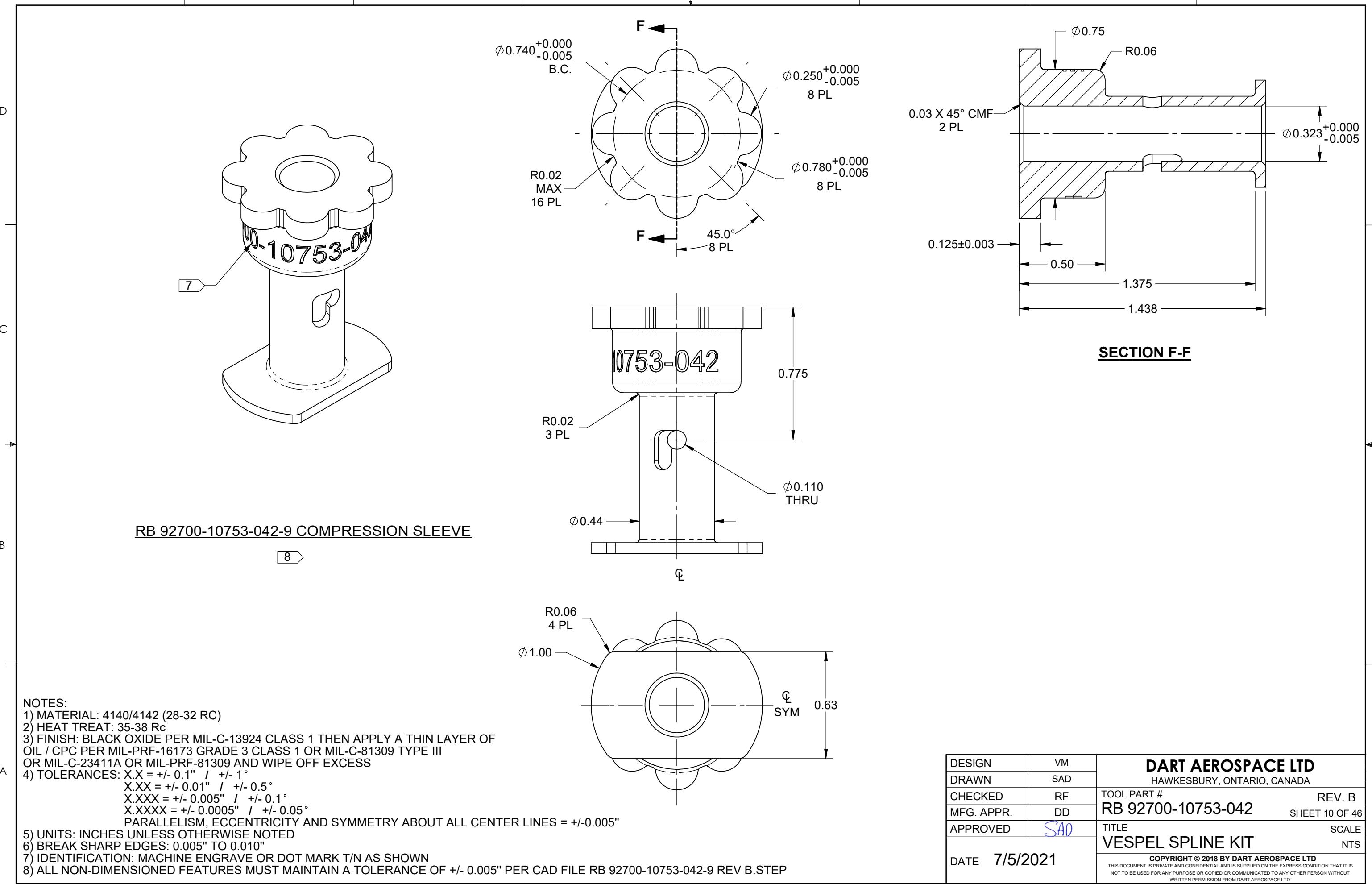
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8 7 6 5 4 3 2 1

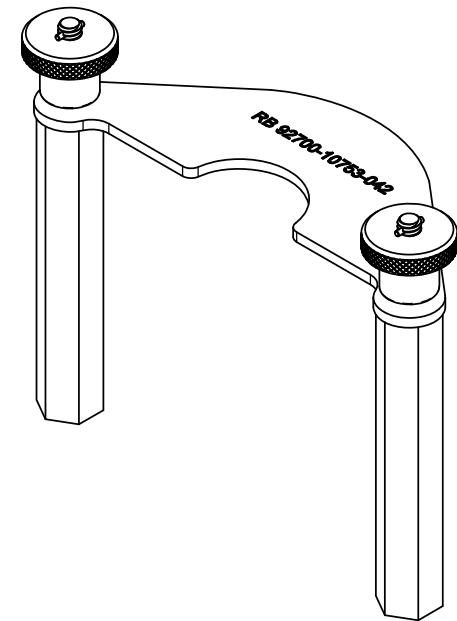
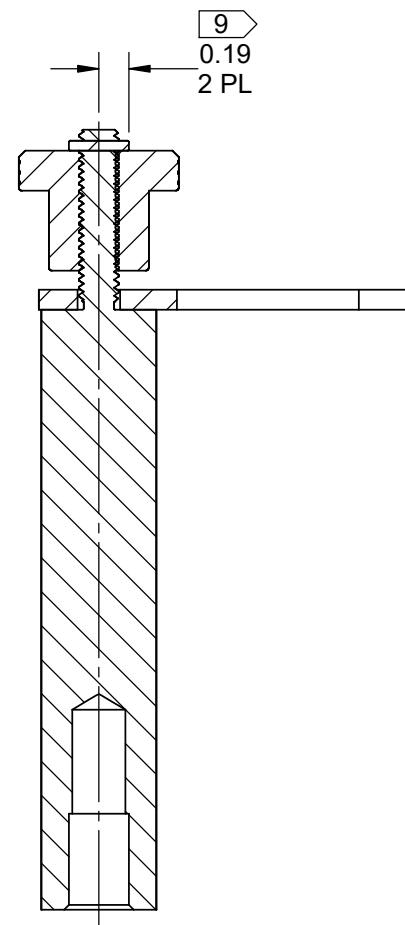
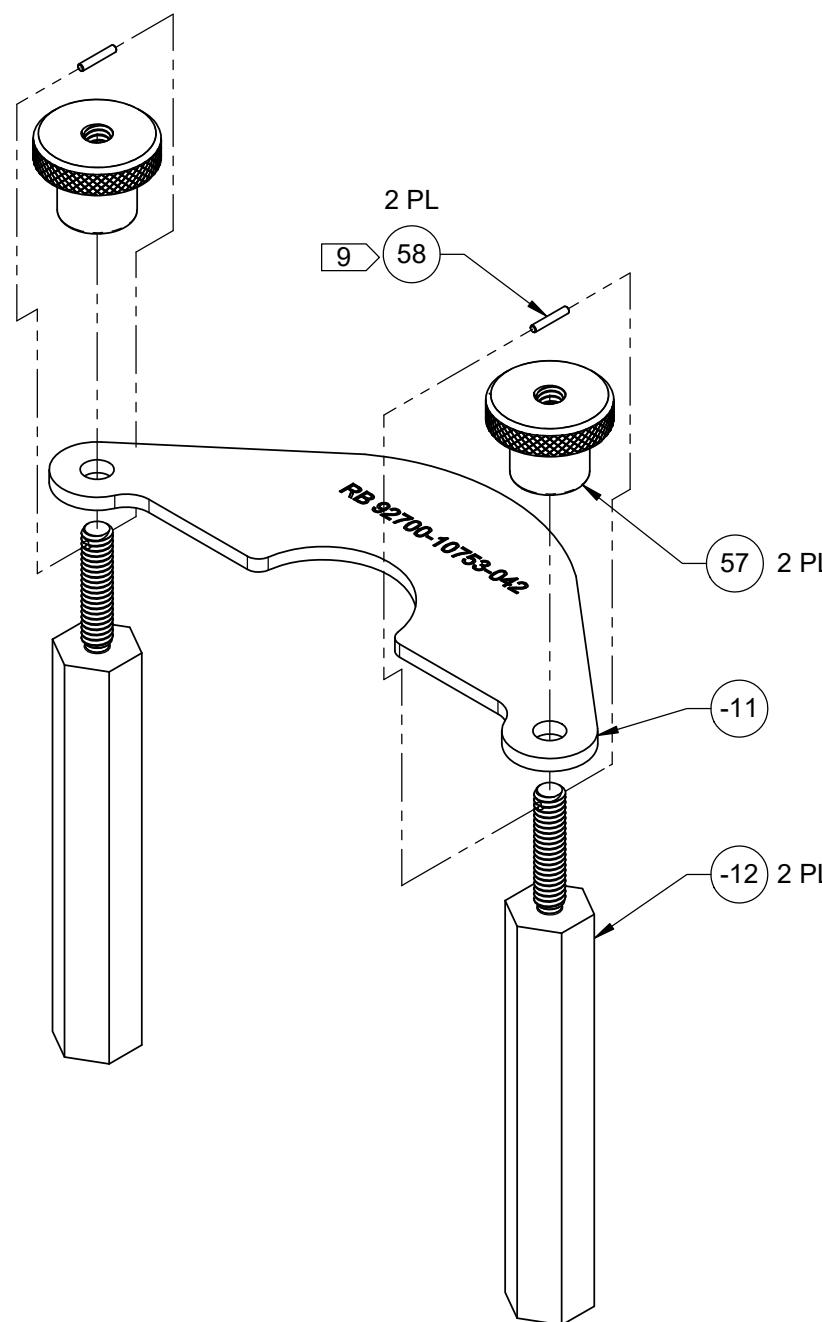




8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-11	1	RB 92700-10753-042-11	PLATE
-12	2	RB 92700-10753-042-12	LEG
57	2	McMaster#6121K311 OR EQUIV	STEEL KNOB 1/4"-20 THREADED THRU HOLE
58	2	McMaster#98381A417 OR EQUIV	STEEL DOWEL PIN 1/16" DIA. X 3/8" LG.

D



RB 92700-10753-042-10 GENERATOR GUIDE PLATE ASSY

10

NOTES:

1) MATERIAL: N/A

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

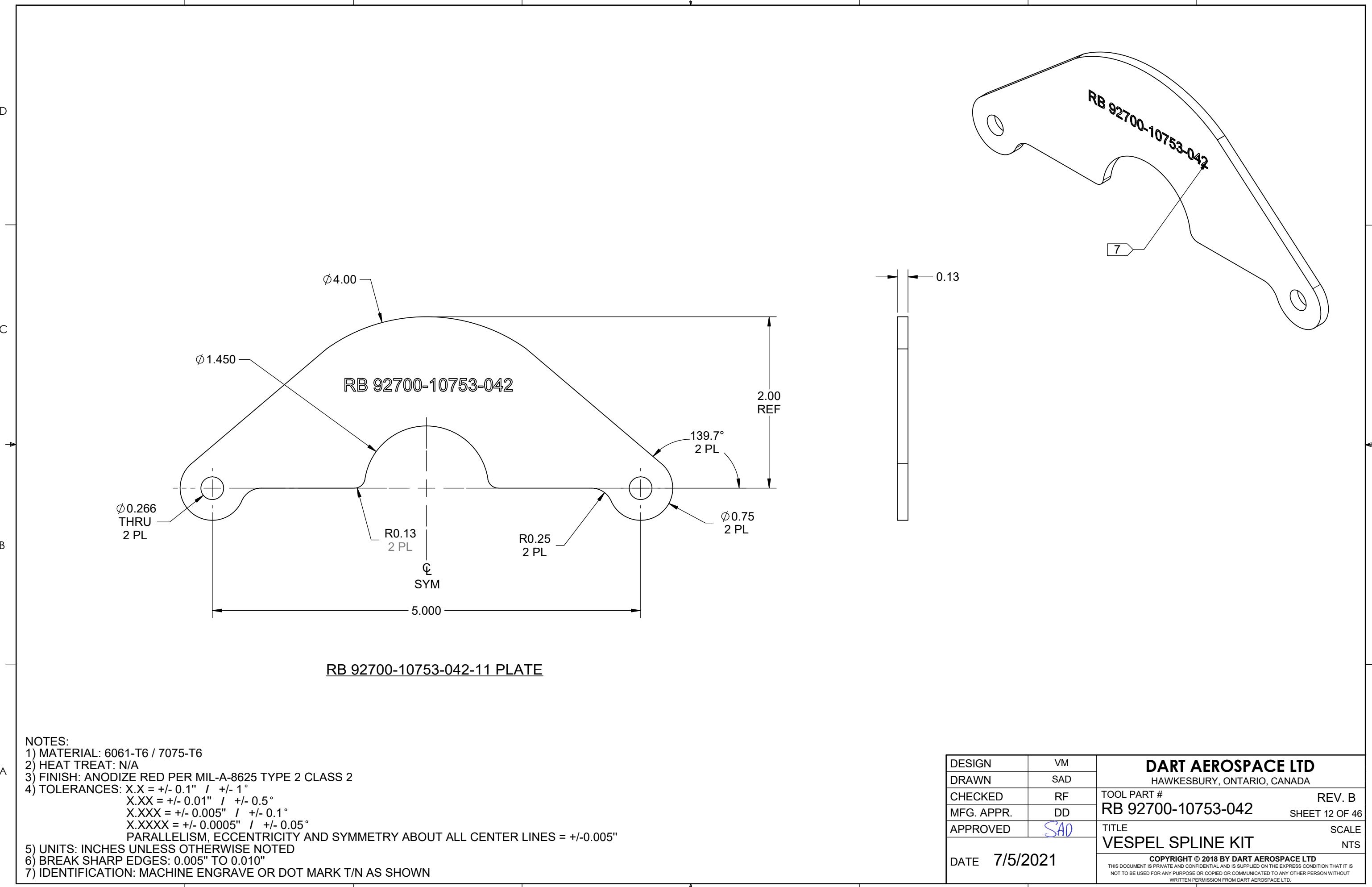
7) IDENTIFICATION: N/A

8) ASSEMBLE AS SHOWN

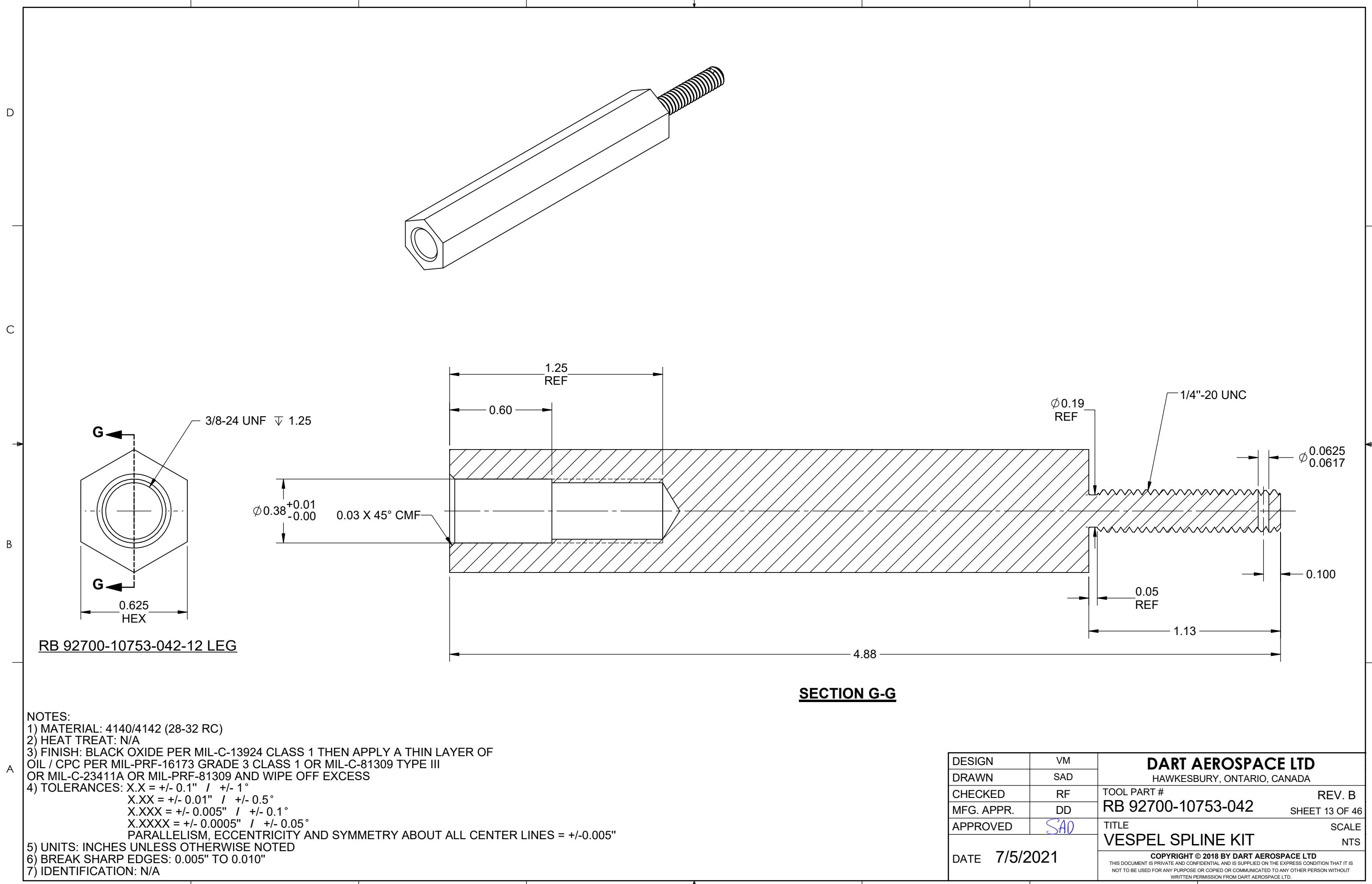
9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEMS 58 CENTERED WITH ITEM -12 AND REMOVE EXCESS

10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD			
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA			
CHECKED	RF	TOOL PART #			
MFG. APPR.	DD	REV. B			
APPROVED	SAD	RB 92700-10753-042			
DATE 7/5/2021		SHEET 11 OF 46			
TITLE VESPEL SPLINE KIT		SCALE NTS			
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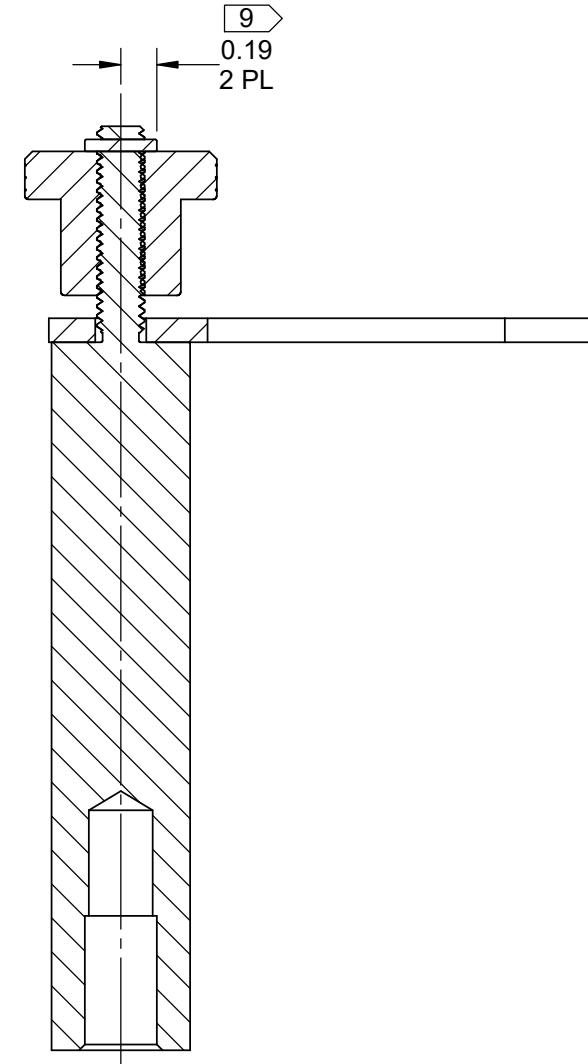
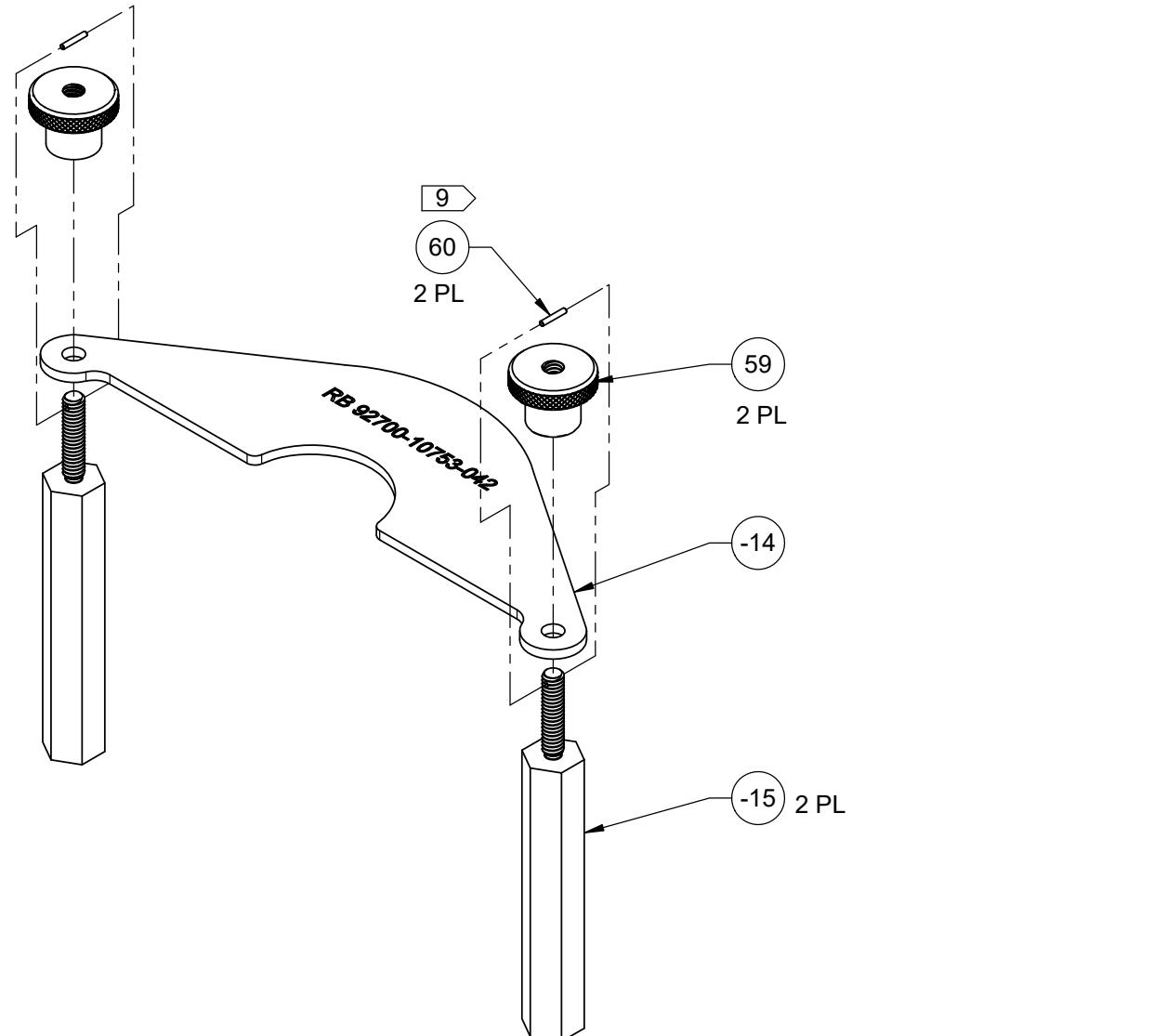


8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-14	1	RB 92700-10753-042-14	PLATE
-15	2	RB 92700-10753-042-15	LEG
59	2	McMaster#6121K311 OR EQUIV	STEEL KNOB 1/4"-20 THREADED THRU HOLE
60	2	McMaster#98381A417 OR EQUIV	STEEL DOWEL PIN 1/16" DIA. x 3/8" LG.



RB 92700-10753-042-13 HYD PUMP GUIDE PLATE ASSY

[10]

NOTES:

1) MATERIAL: N/A

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

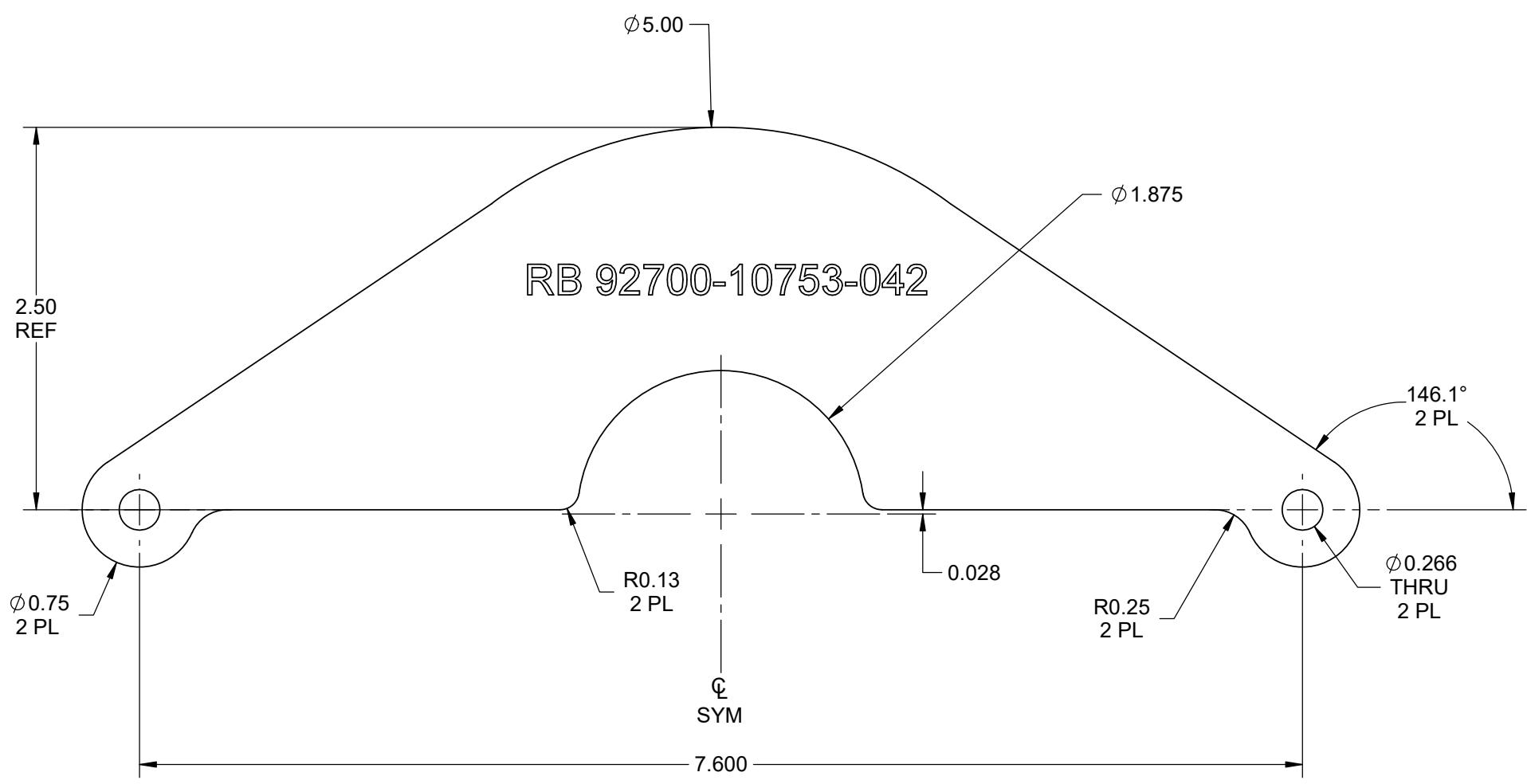
7) IDENTIFICATION: N/A

8) ASSEMBLE AS SHOWN

9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEMS 60 CENTERED WITH ITEM -15 AND REMOVE EXCESS

10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	TOOL PART #	
MFG. APPR.	DD	REV. B	
APPROVED	SAD	RB 92700-10753-042	
DATE 7/5/2021		SHEET 14 OF 46	
TITLE VESPEL SPLINE KIT		SCALE NTS	
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RB 92700-10753-042-14 PLATE

NOTES:

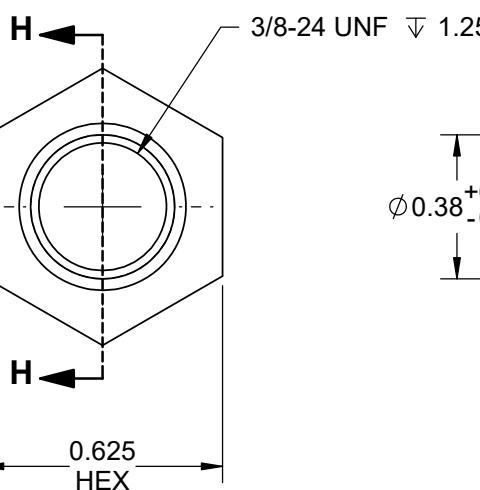
- NOTES:

 - 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

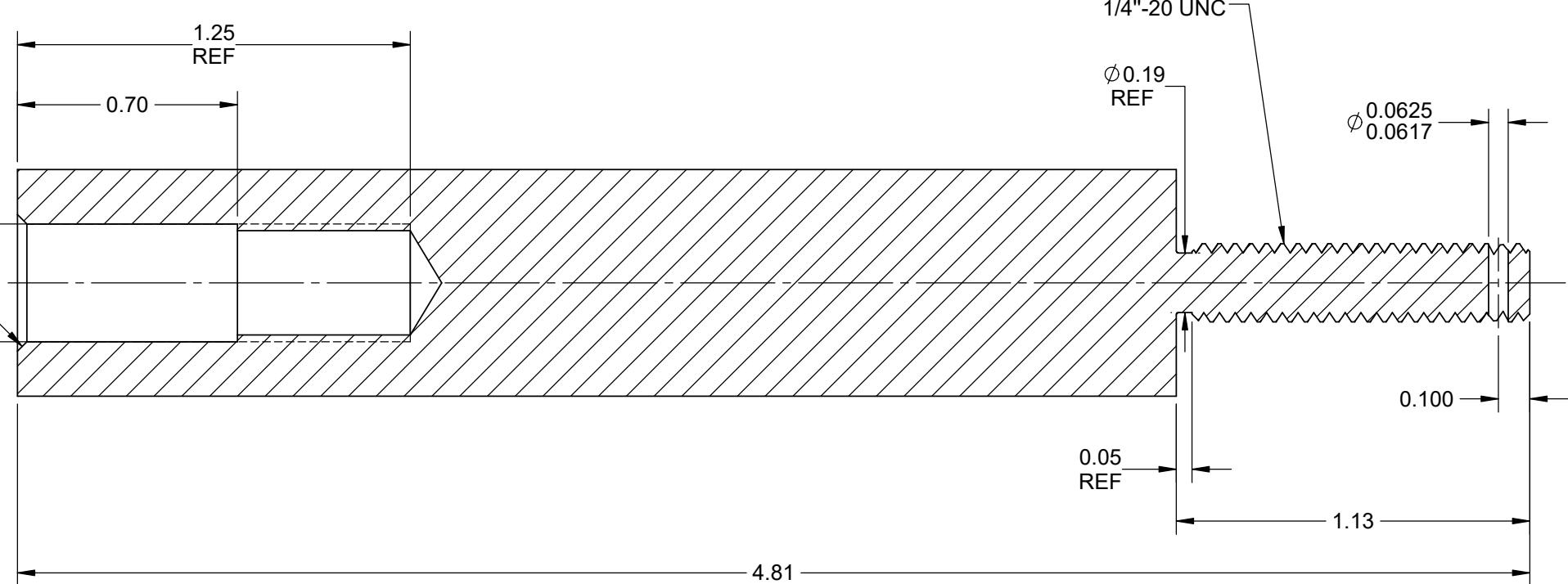
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	RF	TOOL PART #	REV. B
MFG. APPR.	DD	RB 92700-10753-042	SHEET 15 OF 46
APPROVED	<i>SAD</i>	TITLE	SCALE
		VESPEL SPLINE KIT	NTS
DATE	7/5/2021	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	

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RB 92700-10753-042-15 LEG



SECTION H-H

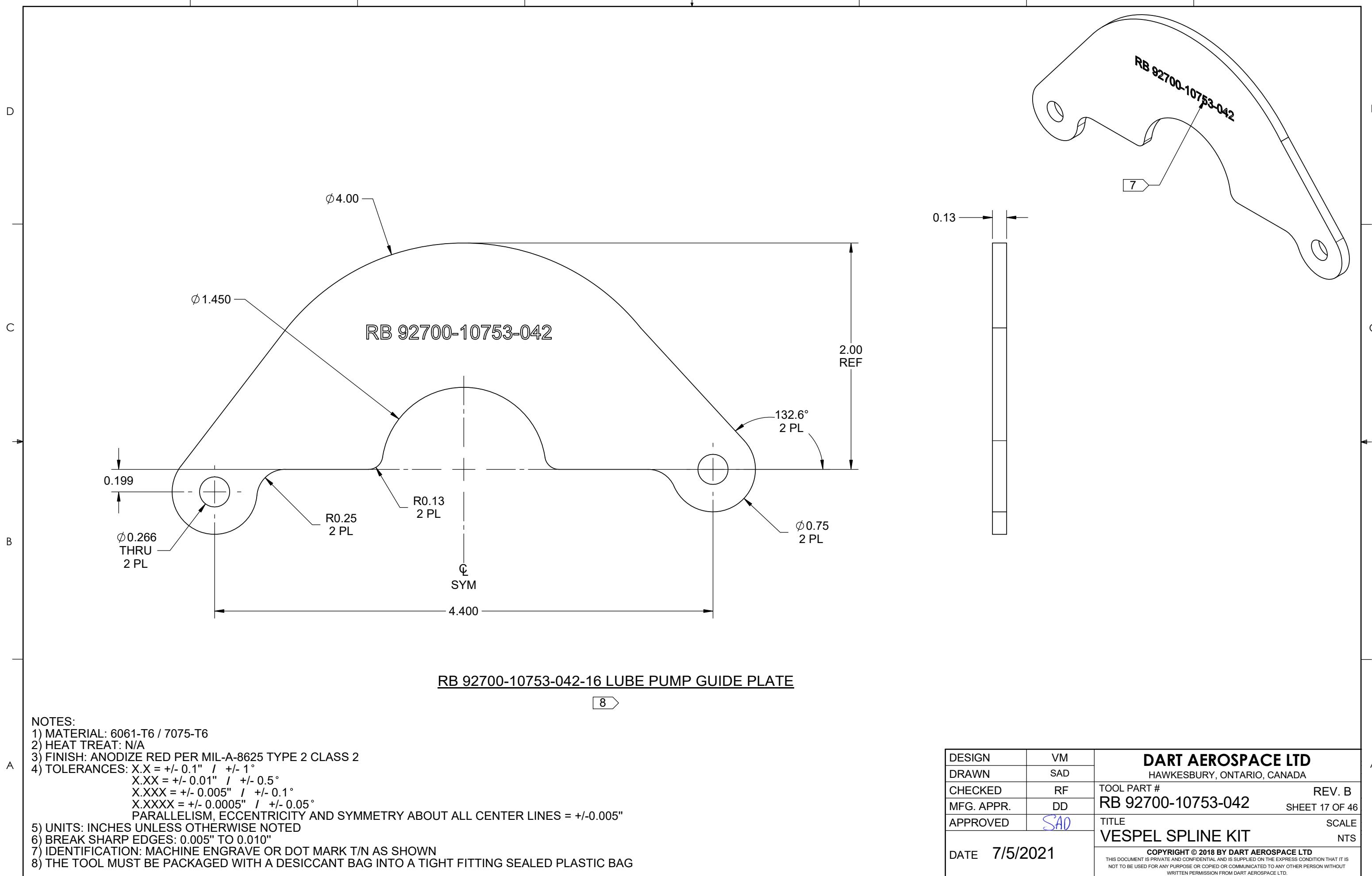
NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

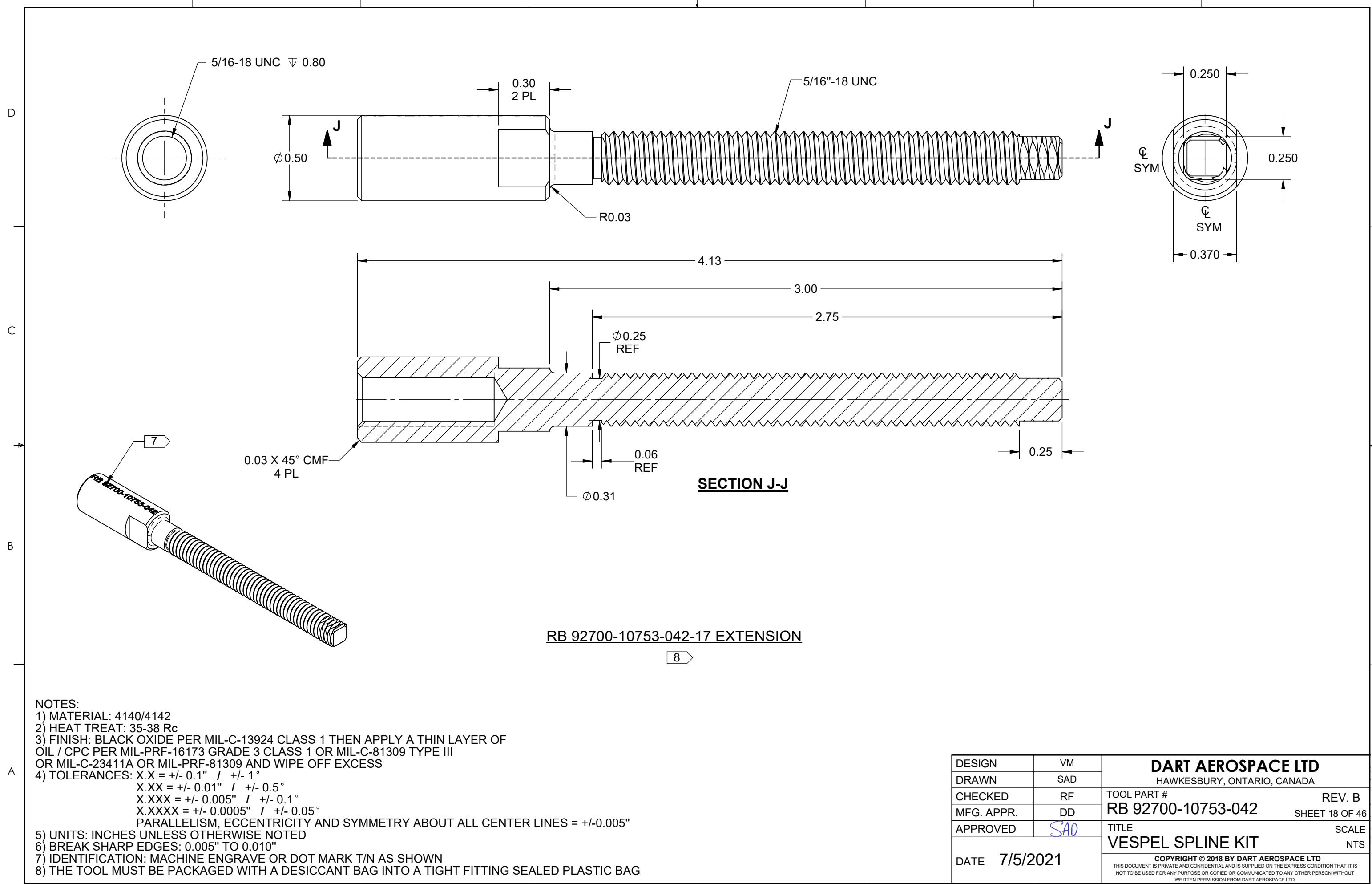
- PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD			
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA			
CHECKED	RF	TOOL PART #			
MFG. APPR.	DD	REV. B			
APPROVED	SAD	RB 92700-10753-042			
DATE 7/5/2021		SHEET 16 OF 46			
TITLE VESPEL SPLINE KIT		SCALE NTS			
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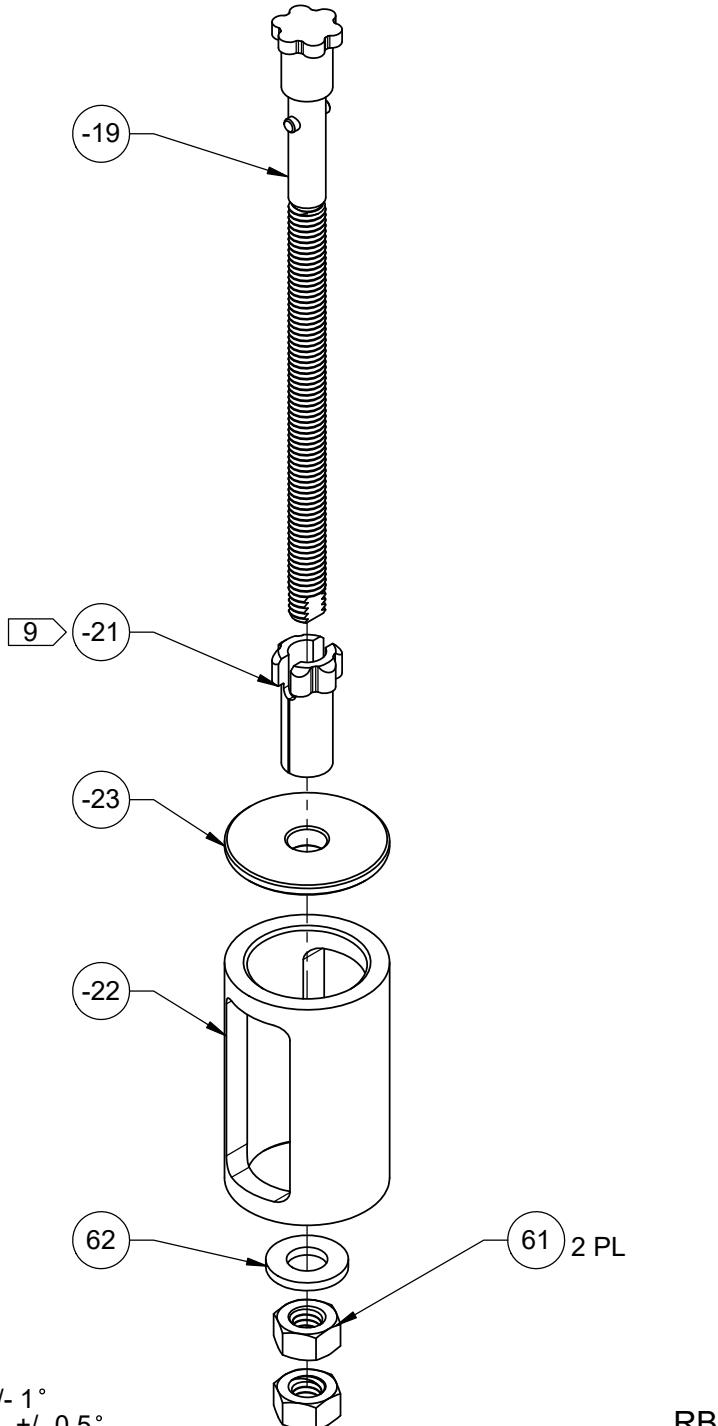


8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-19	1	RB 92700-10753-042-19	PIN ASSY
-21	1	RB 92700-10753-042-21	SLEEVE
-22	1	RB 92700-10753-042-22	GUIDE
-23	1	RB 92700-10753-042-23	CAP
61	2	McMaster#94895A030 OR EQUIV	STEEL HEX NUT 5/16"-18
62	1	McMaster#98023A030 OR EQUIV.	YELLOW ZINC PLATED GRADE 8 STEEL WASHER 0.344" ID X 0.688" OD. X 0.051"-0.080" THK.

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NOTES:

1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: N/A

8) ASSEMBLE AS SHOWN

9) SLOT OF ITEM -21 MUST ALIGN WITH DOWEL PIN OF ITEM -19

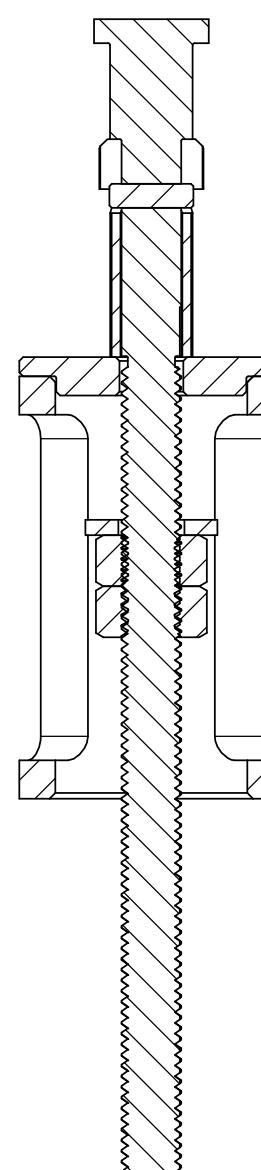
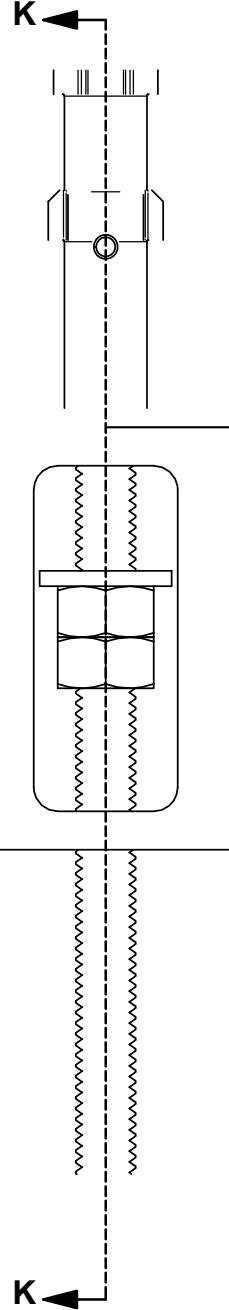
10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

RB 92700-10753-042-18 APU SPLINE REMOVAL TOOL

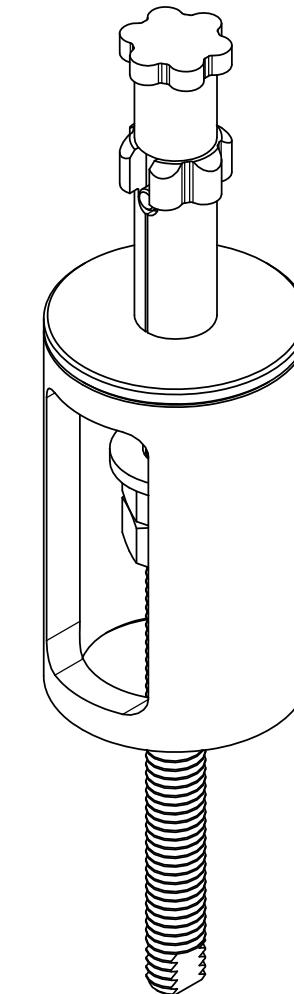
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SECTION K-K



DESIGN	VM	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	TOOL PART #
MFG. APPR.	DD	REV. B
APPROVED	SAD	RB 92700-10753-042
		Sheet 19 of 46
DATE	7/5/2021	TITLE
		VESPEL SPLINE KIT
		SCALE
		NTS
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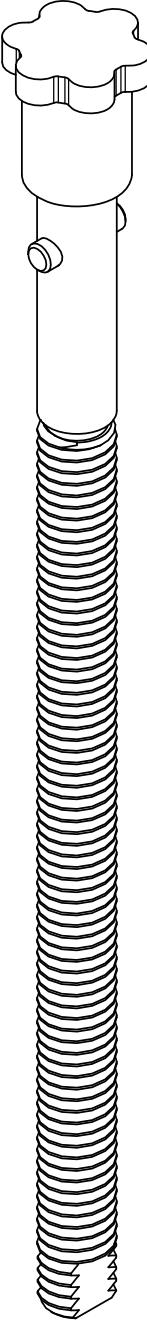
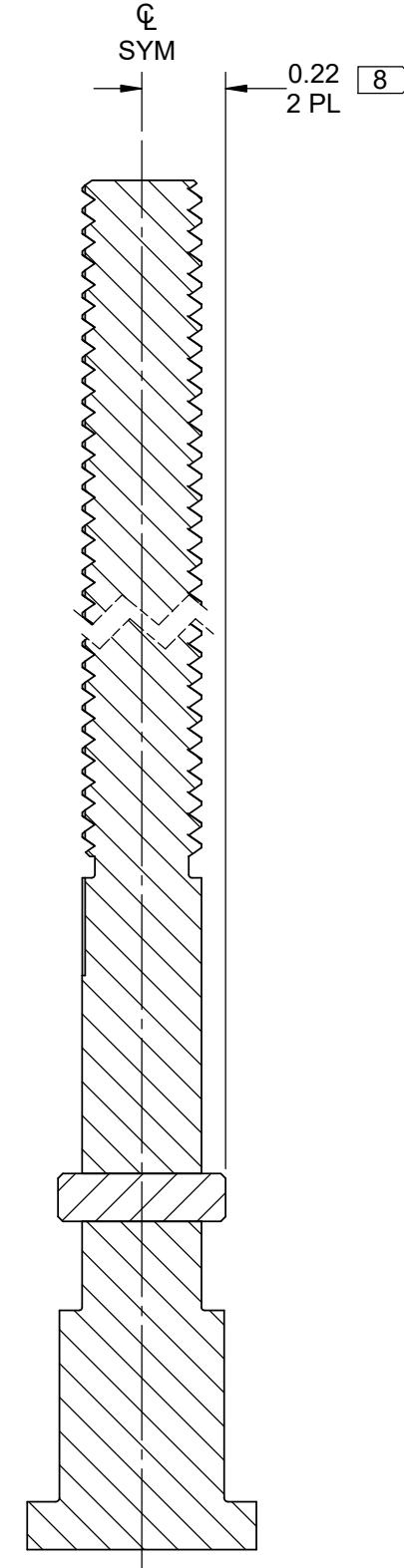
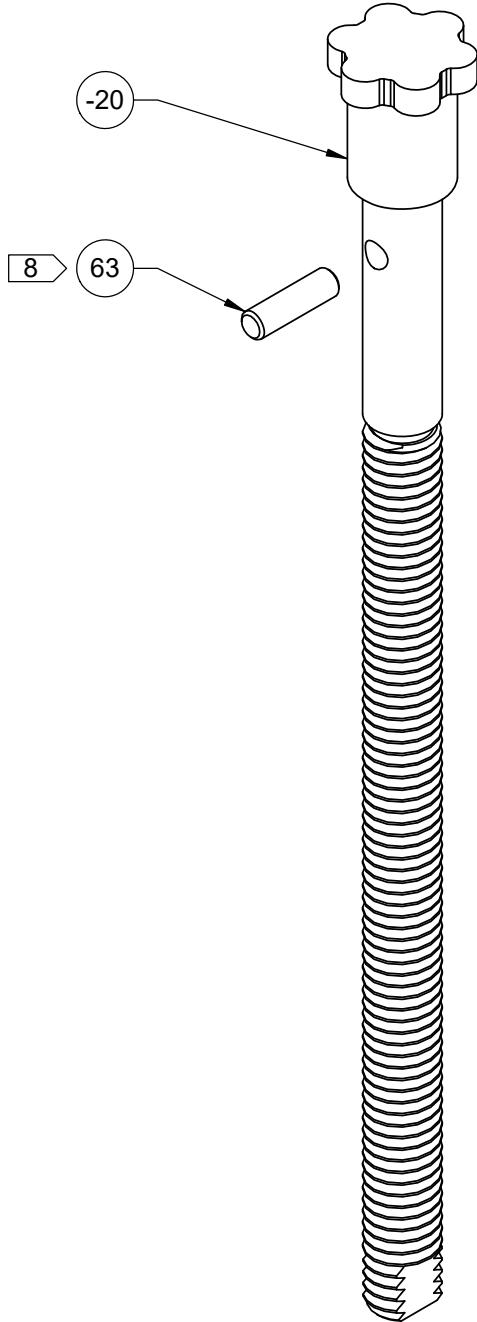
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8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-20	1	RB 92700-10753-042-20	PIN
63	1	McMaster#98381A218 OR EQUIV	STEEL DOWEL PIN 1/8" DIA. x 7/16" LG.

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NOTES:

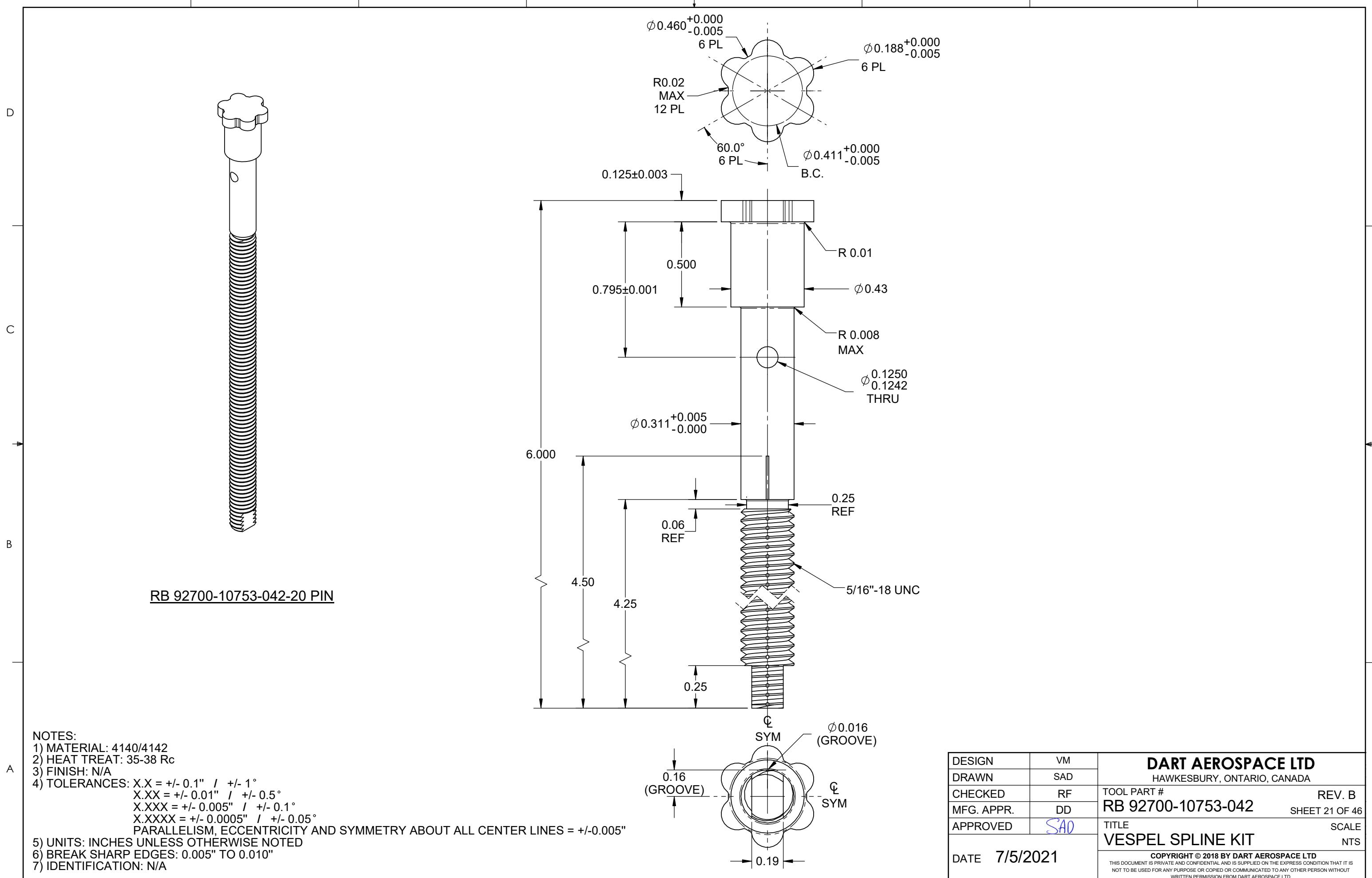
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

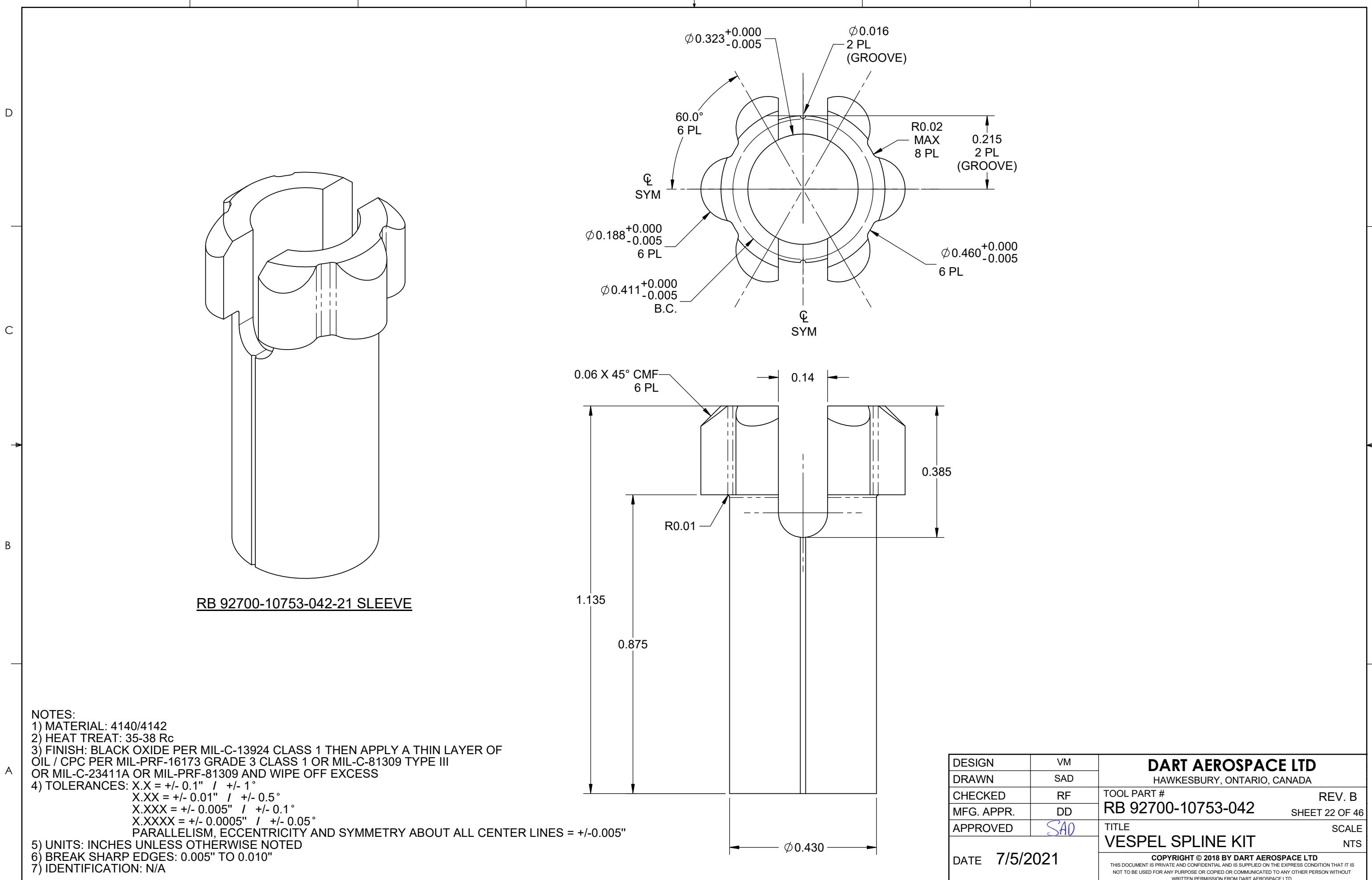
8) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEMS 63 CENTERED WITH ITEM -20 AND REMOVE EXCESS

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	SAD	
CHECKED	RF	
MFG. APPR.	DD	
APPROVED	SAD	
DATE	7/5/2021	
TOOL PART #	RB 92700-10753-042	REV. B
		SHEET 20 OF 46
TITLE	VESPEL SPLINE KIT	SCALE
		NTS
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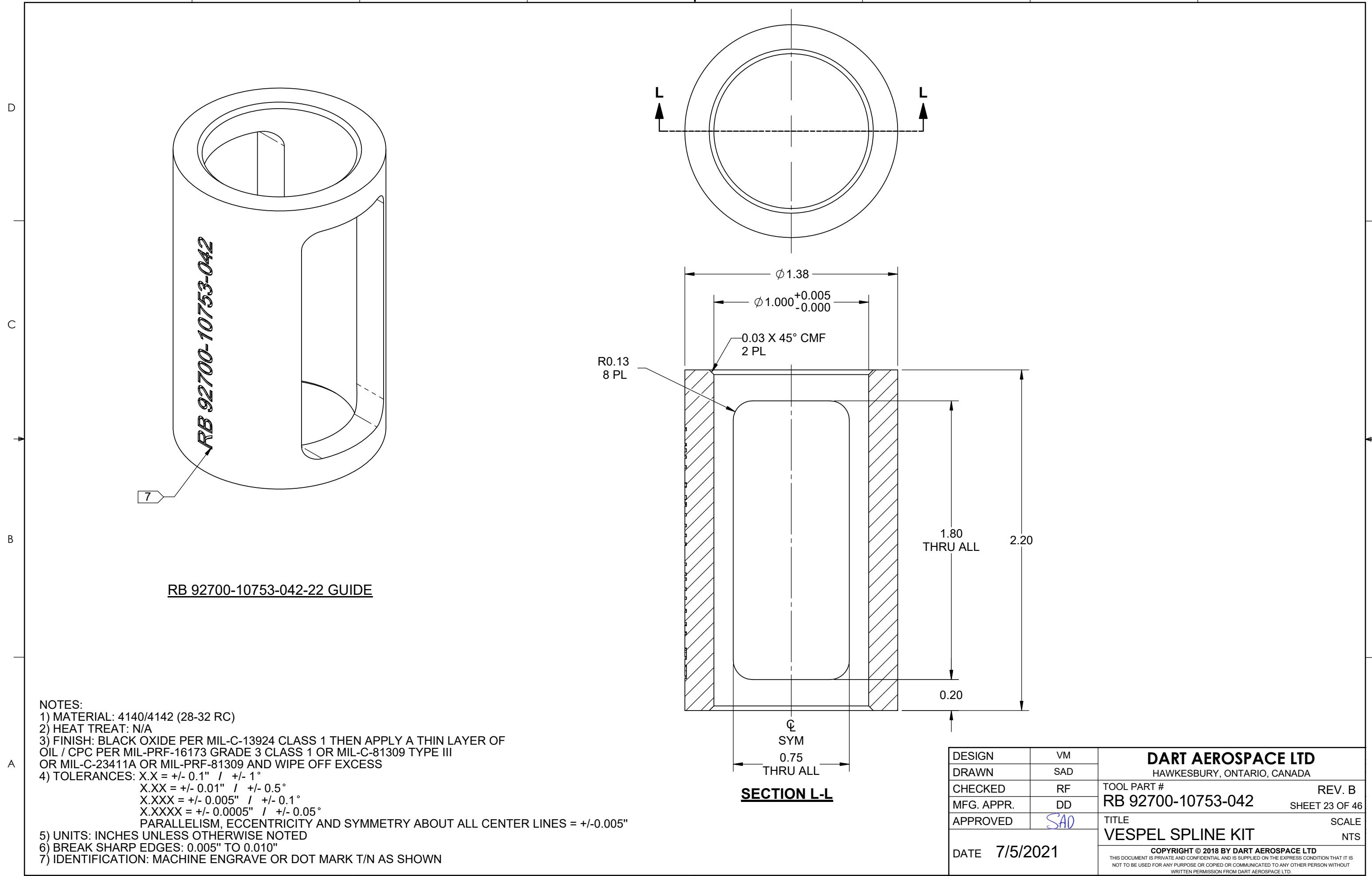
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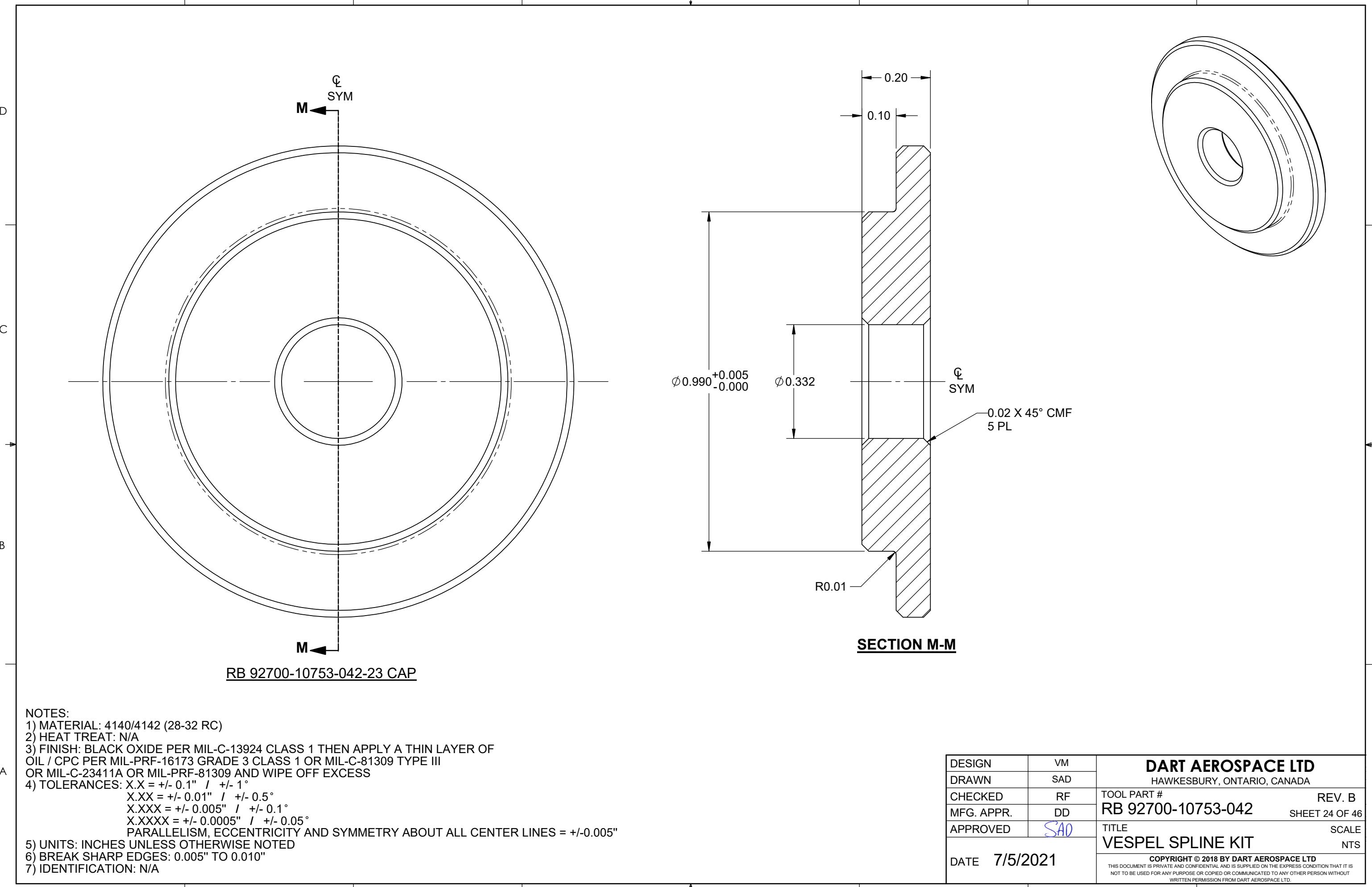


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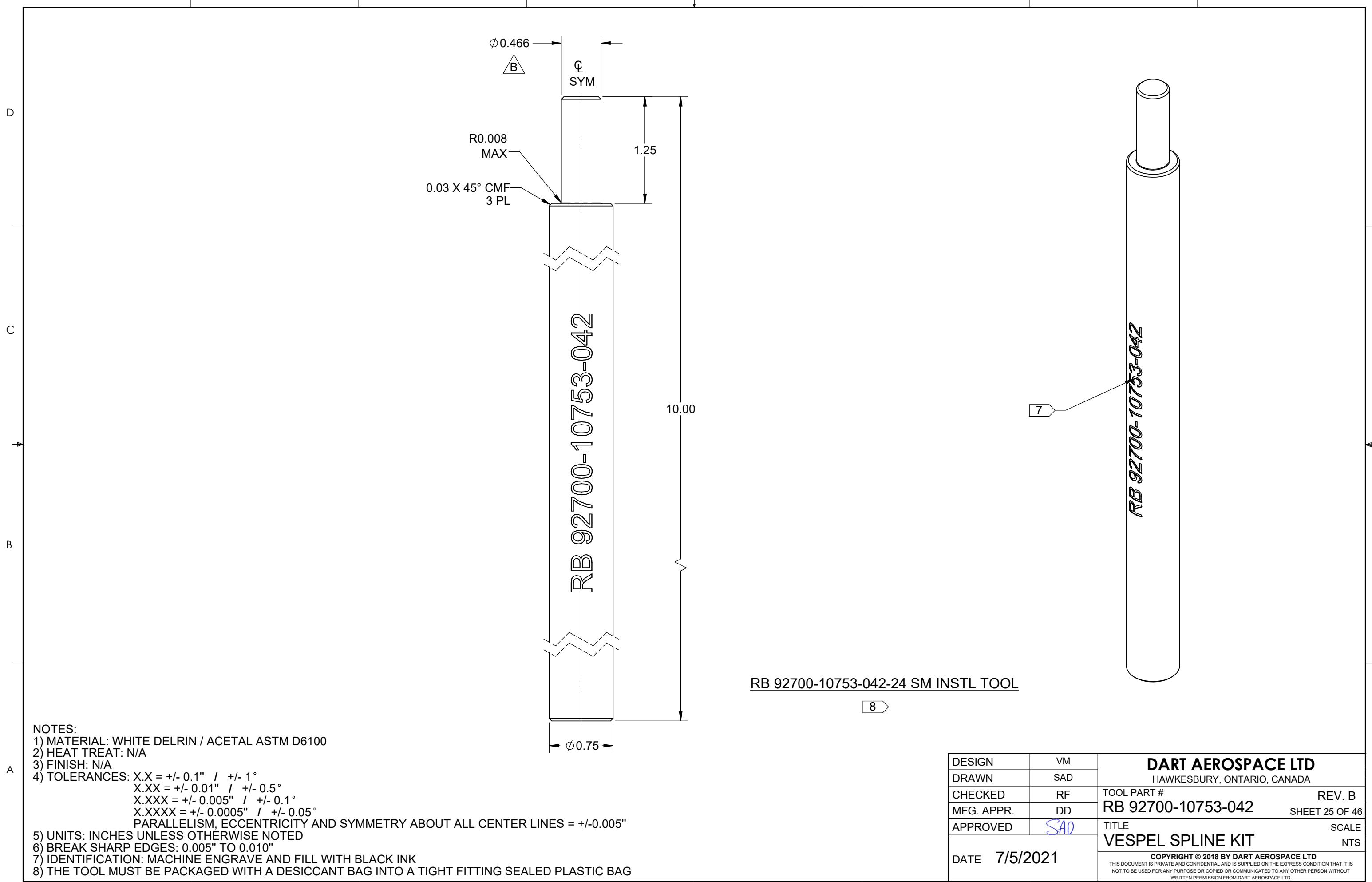


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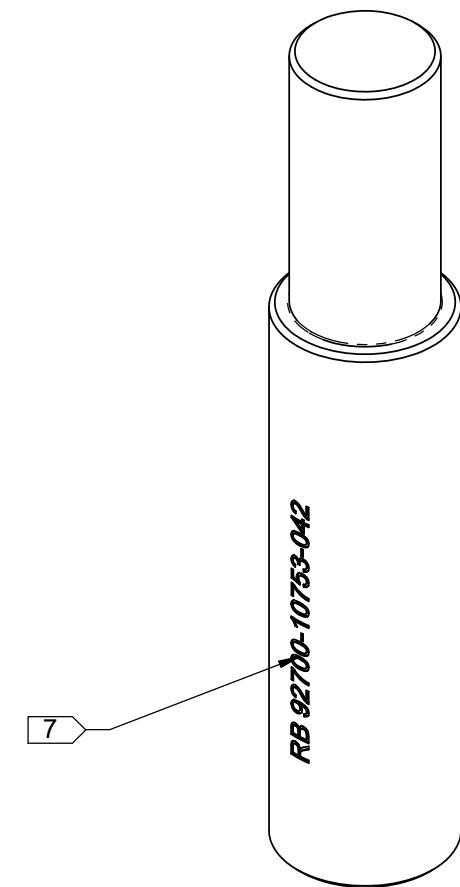
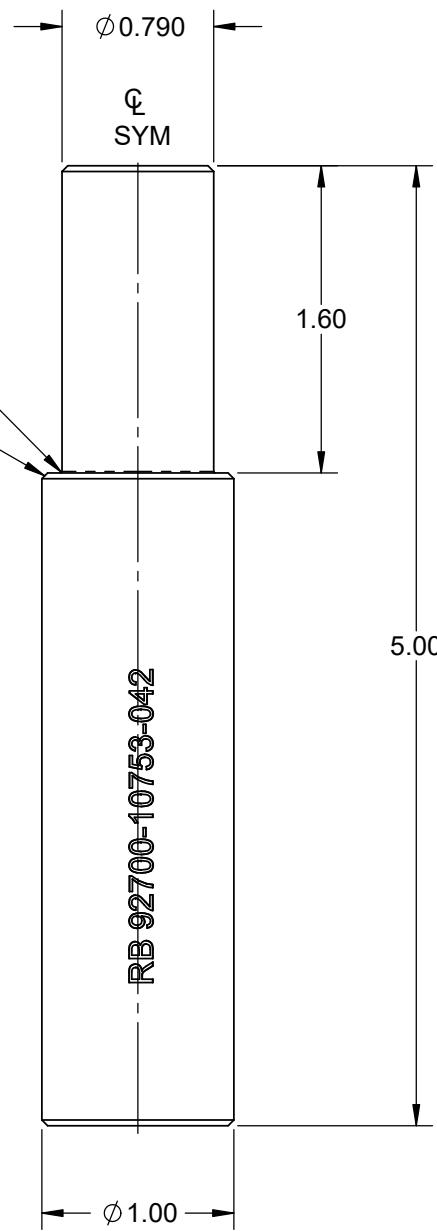
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RB 92700-10753-042-25 LG INSTL TOOL

8

NOTES:

1) MATERIAL: WHITE DELRIN / ACETAL ASTM D6100

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: MACHINE ENGRAVE AND FILL WITH BLACK INK

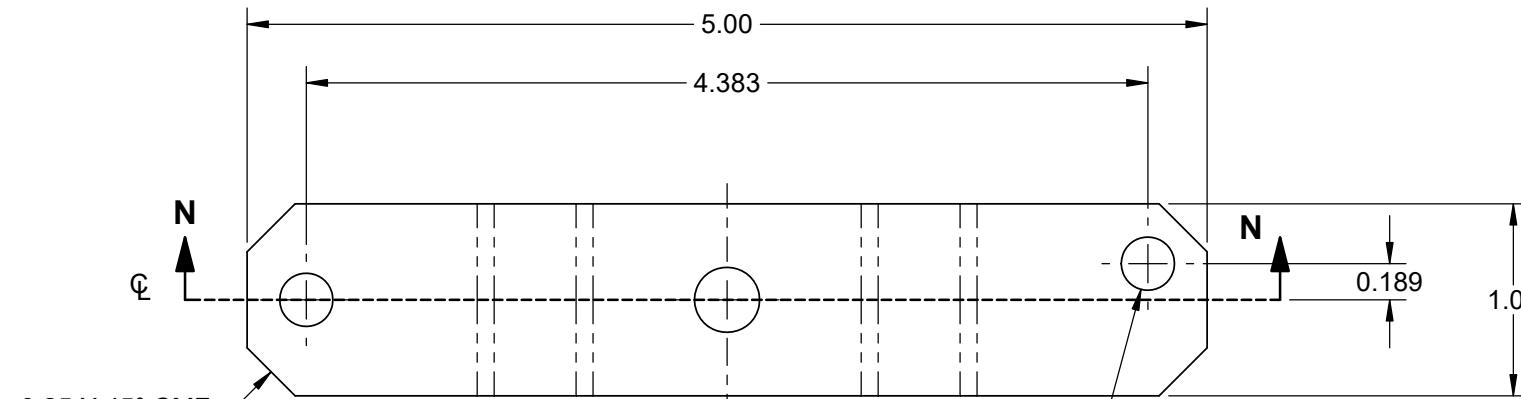
8) THE TOOL MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD			
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA			
CHECKED	RF	TOOL PART #			
MFG. APPR.	DD	REV. B			
APPROVED	SAD	RB 92700-10753-042			
DATE 7/5/2021		SHEET 26 OF 46			
TITLE VESPEL SPLINE KIT		SCALE NTS			
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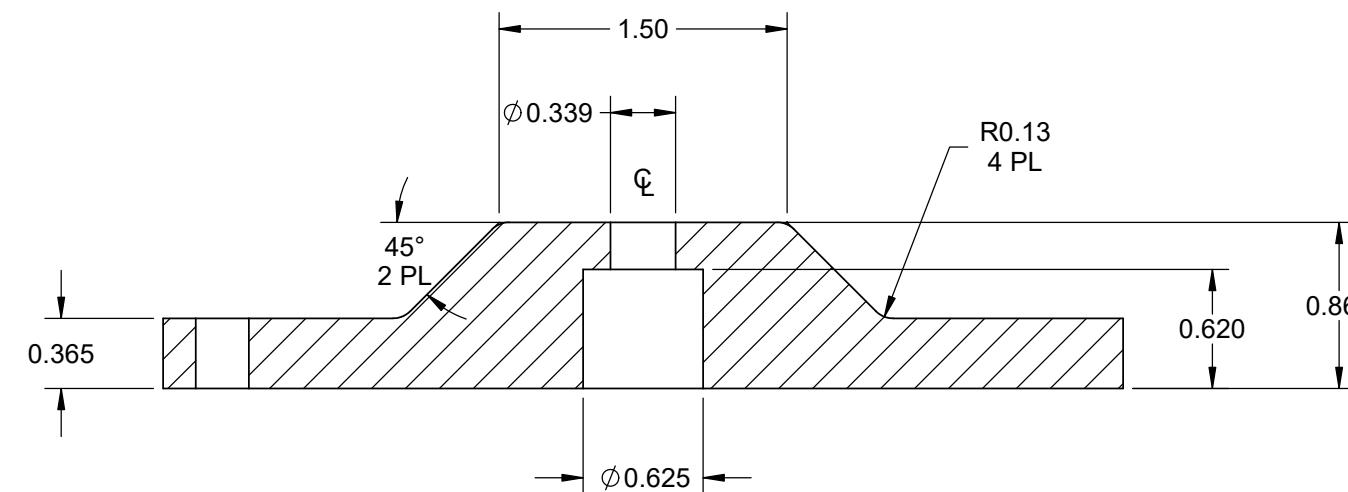
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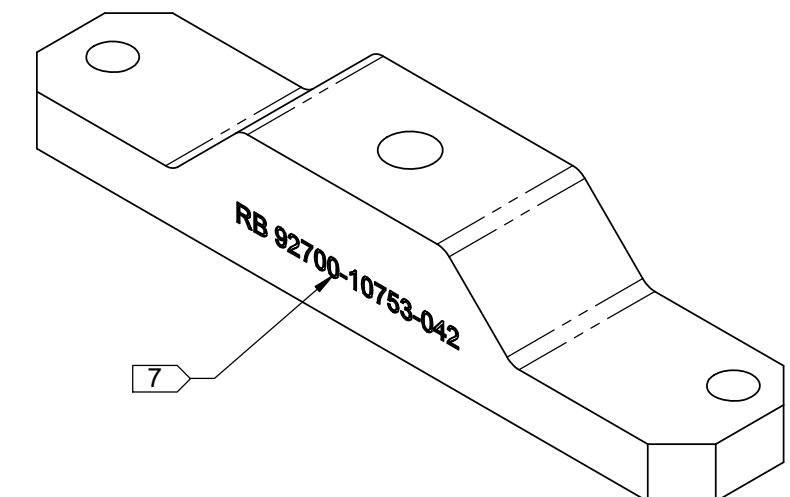


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SECTION N-N



RB 92700-10753-042-26 LUBE PUMP BRIDGE

8

NOTES:

1) MATERIAL: 6061-T6 / 7075-T6

2) HEAT TREAT: N/A

3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

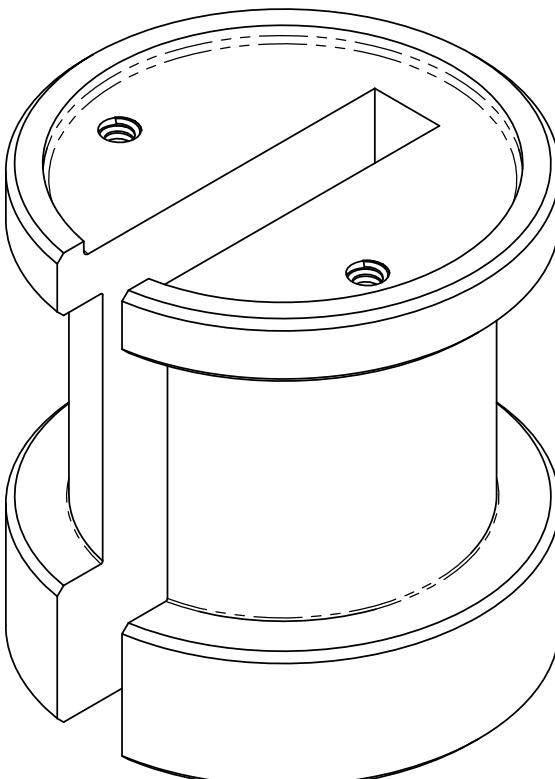
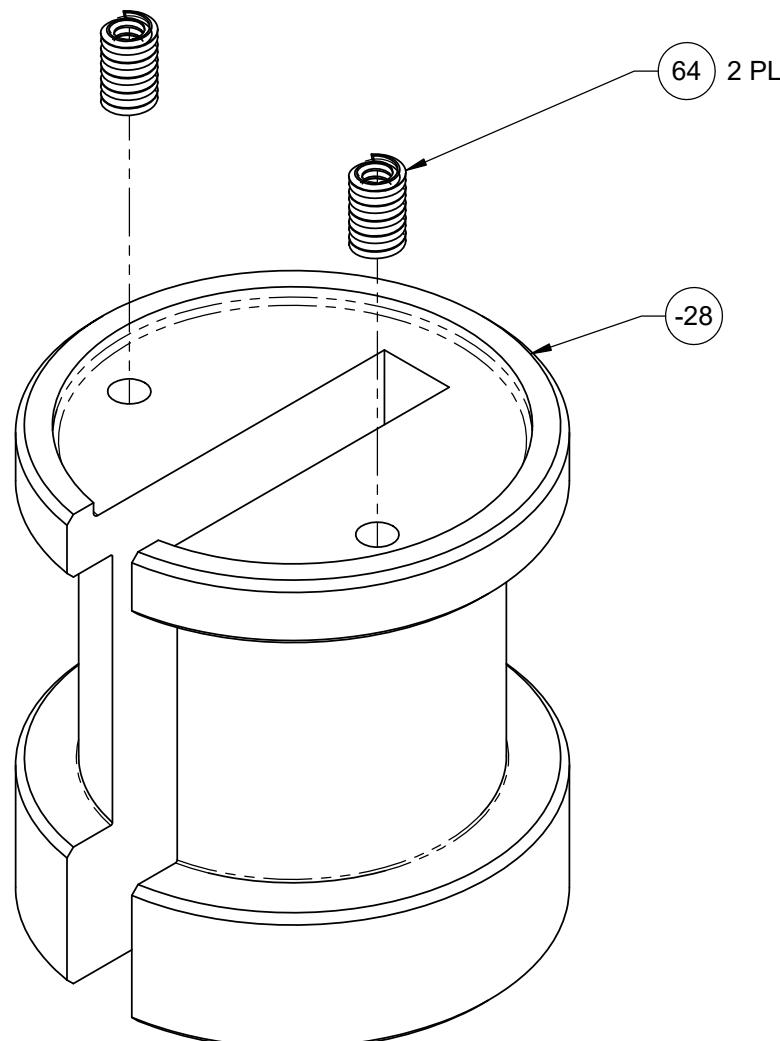
7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL AS SHOWN OR DOT MARK T/N AS SHOWN

8) THE TOOL MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD			
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA			
CHECKED	RF	TOOL PART #			
MFG. APPR.	DD	REV. B			
APPROVED	SAD	RB 92700-10753-042			
DATE 7/5/2021		SHEET 27 OF 46			
TITLE VESPEL SPLINE KIT		SCALE NTS			
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8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-28	1	RB 92700-10753-042-28	GUIDE
64	2	McMaster#91732A708 OR EQUIV	SS THREADED INSERT #6-32 x 0.345" LG



NOTES:

1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: N/A

8) ASSEMBLE AS SHOWN

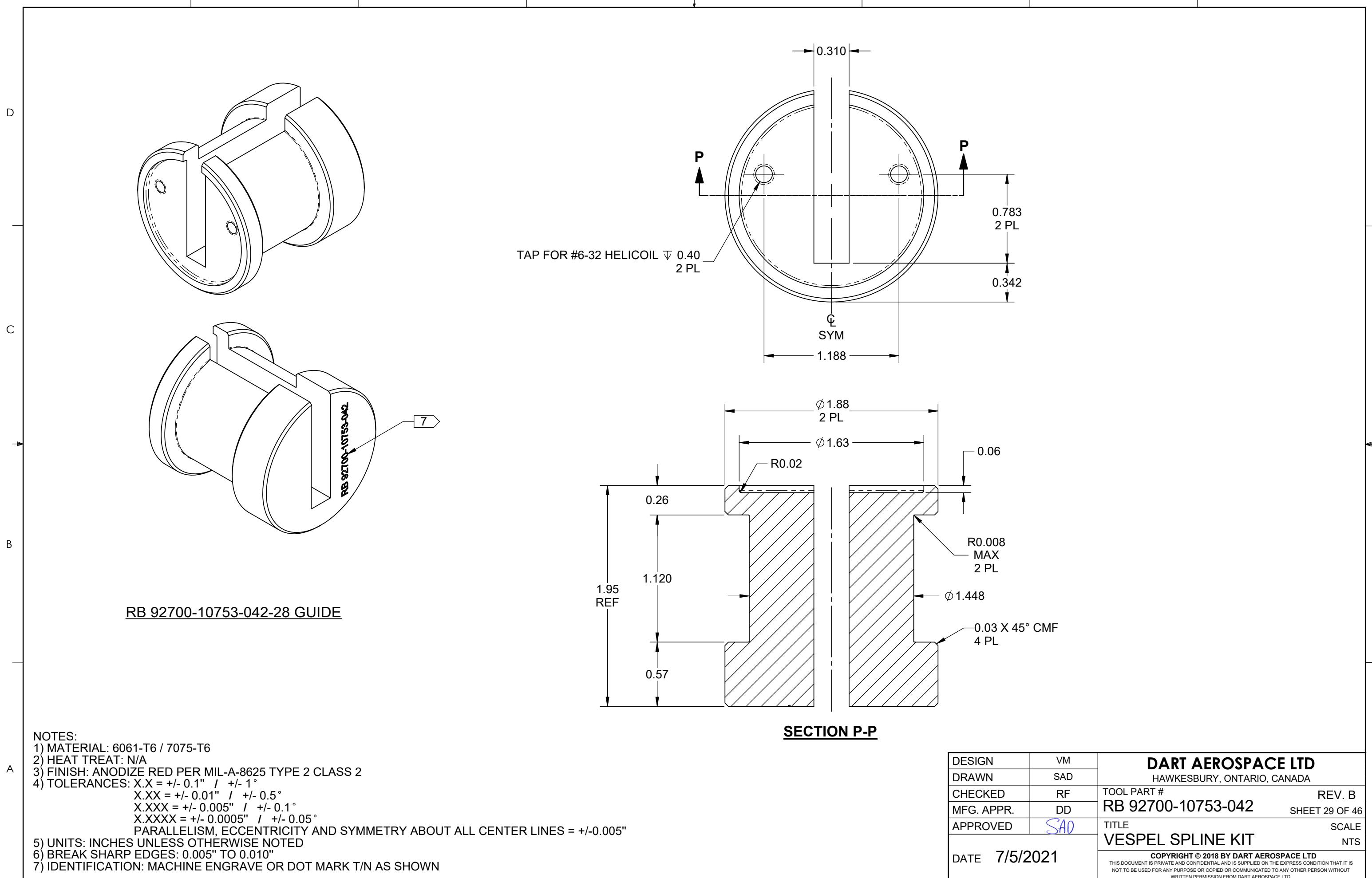
9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

RB 92700-10753-042-27 SMALL GUIDE

9

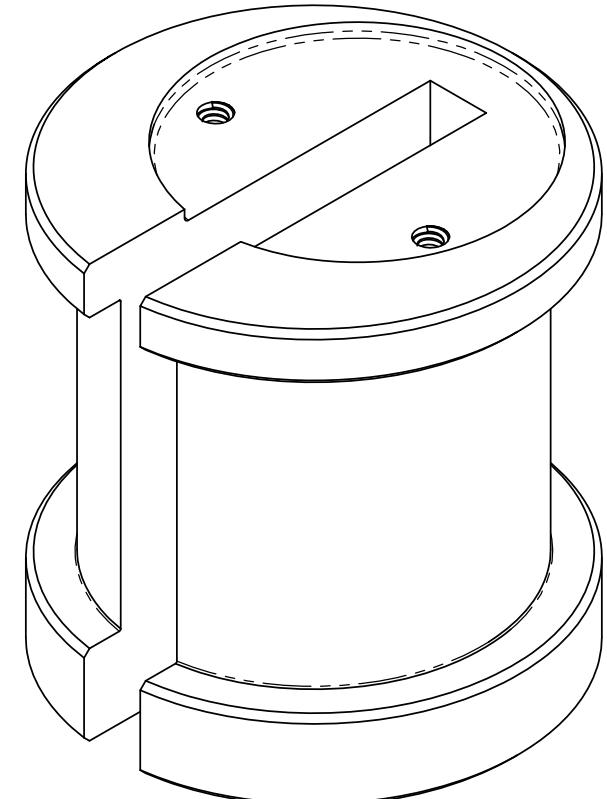
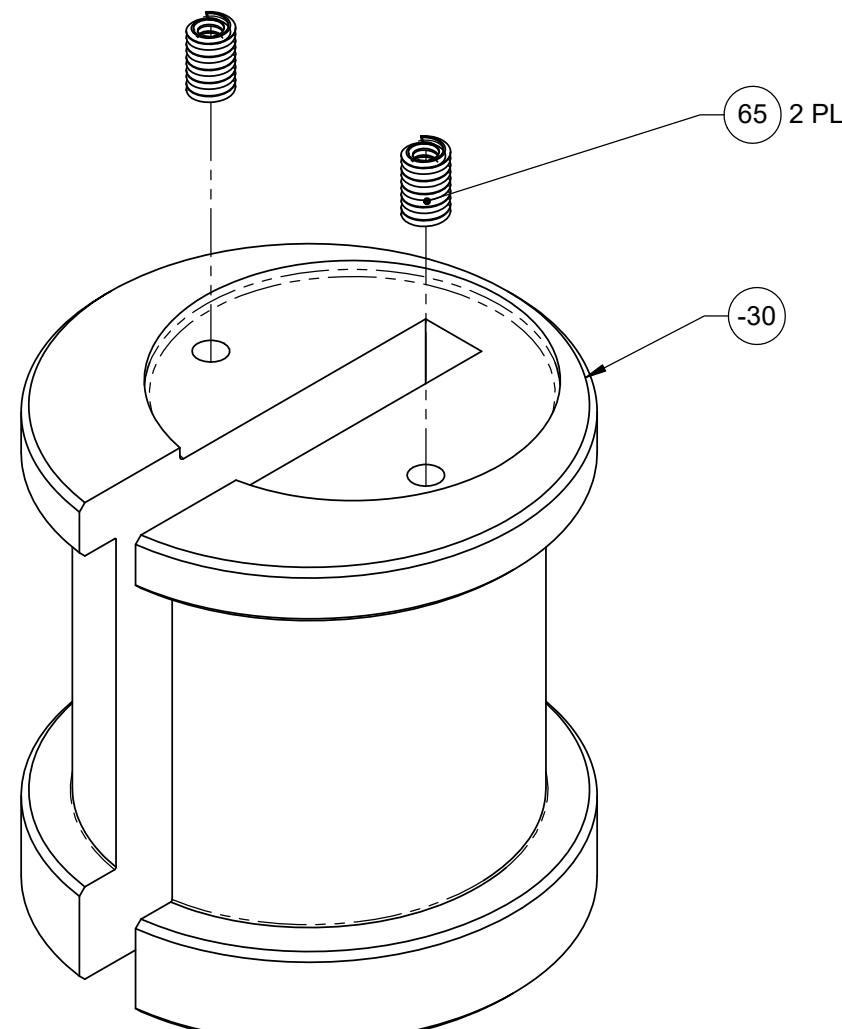
DESIGN	VM	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	TOOL PART #
MFG. APPR.	DD	REV. B
APPROVED	SAD	RB 92700-10753-042
		SHEET 28 OF 46
DATE	7/5/2021	TITLE
		SCALE
		VESPEL SPLINE KIT
		NTS
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-30	1	RB 92700-10753-042-30	GUIDE
65	2	McMaster#91732A708 OR EQUIV	SS THREADED INSERT #6-32 x 0.345" LG



RB 92700-10753-042-29 LARGE GUIDE

9

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

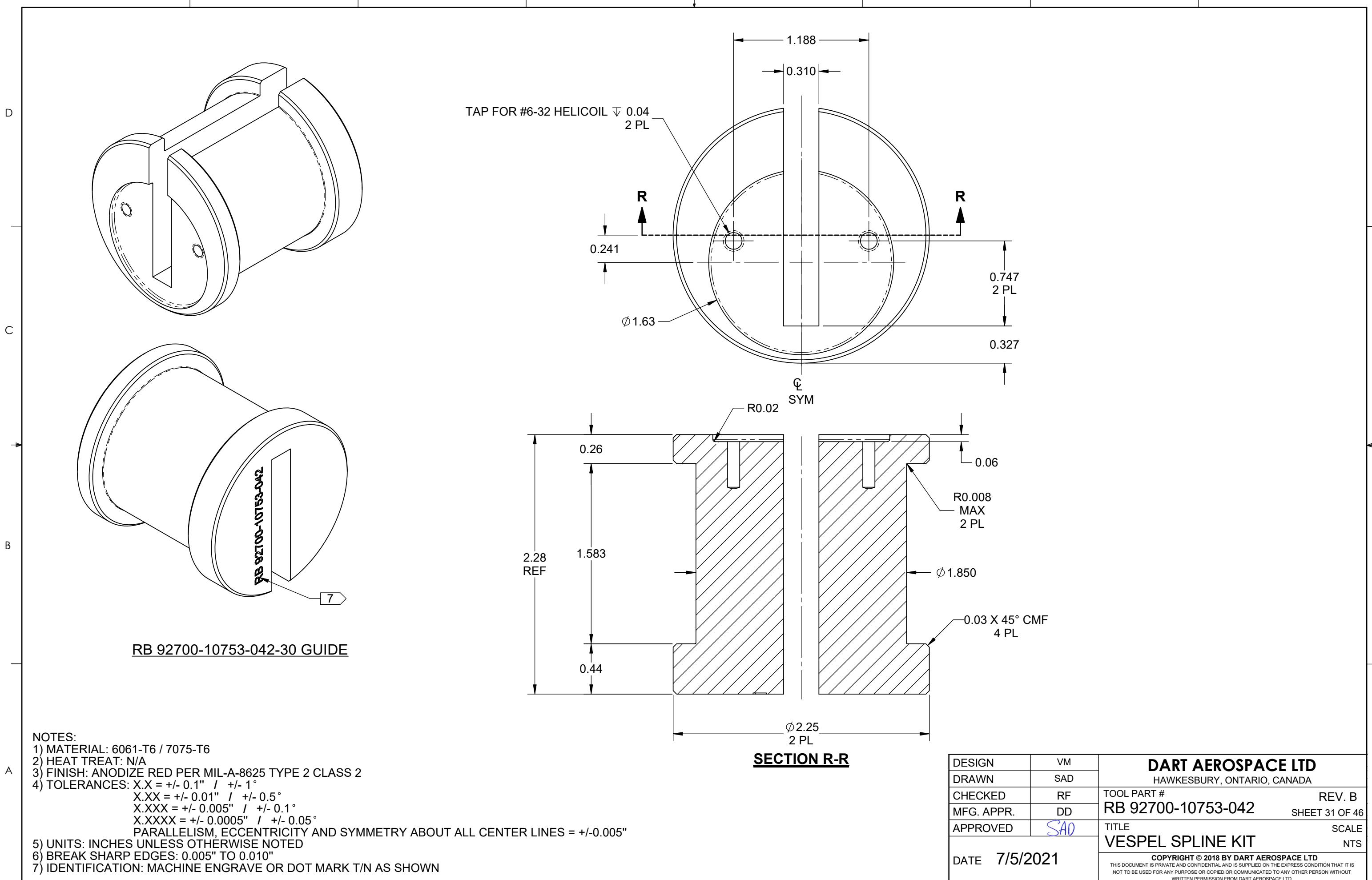
7) IDENTIFICATION: N/A

8) ASSEMBLE AS SHOWN

9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD			
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA			
CHECKED	RF	TOOL PART #			
MFG. APPR.	DD	REV. B			
APPROVED	SAD	RB 92700-10753-042			
DATE 7/5/2021		SHEET 30 OF 46			
TITLE VESPEL SPLINE KIT		SCALE NTS			
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8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-32	1	RB 92700-10753-042-32	HANDLE
-33	1	RB 92700-10753-042-33	PIN
66	1	McMaster#90128A582 OR EQUIV	STEEL SOCKET HEAD CAP SCREW 5/16"-18 x 7/8" LG.

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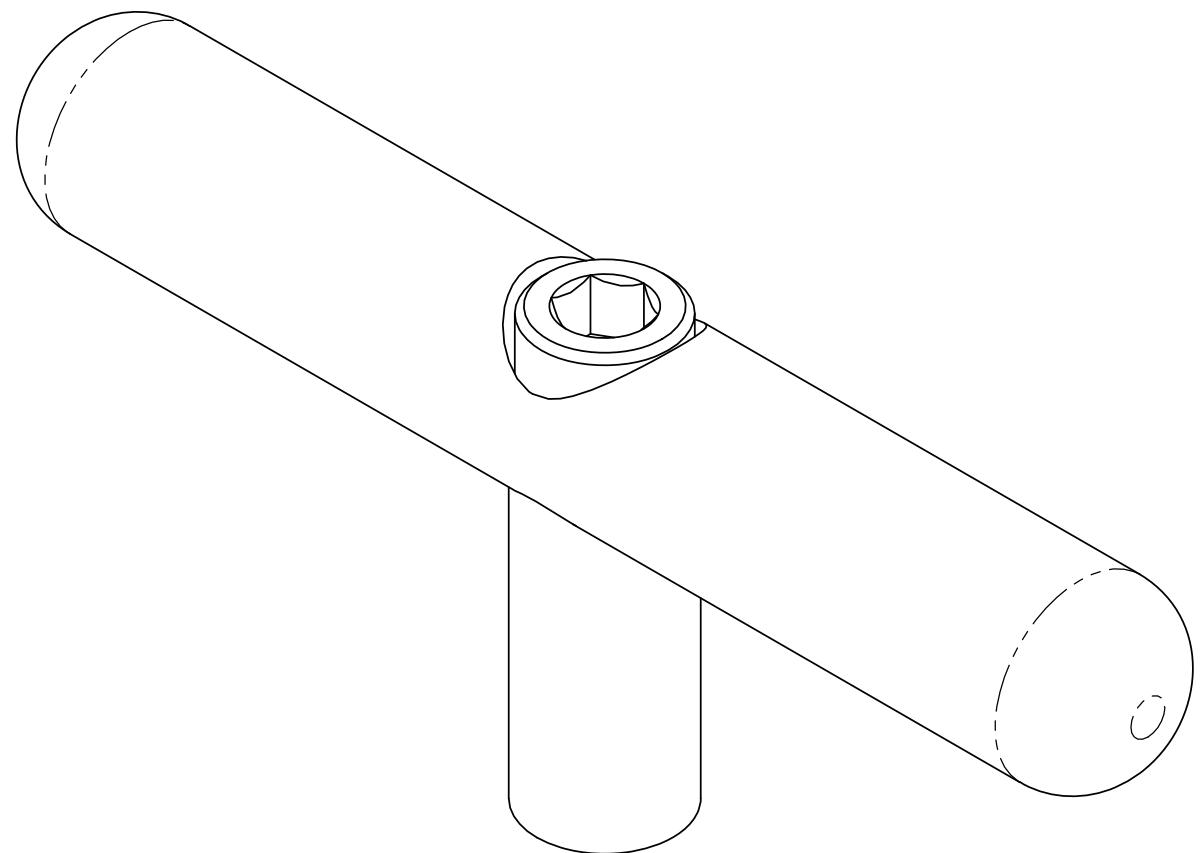
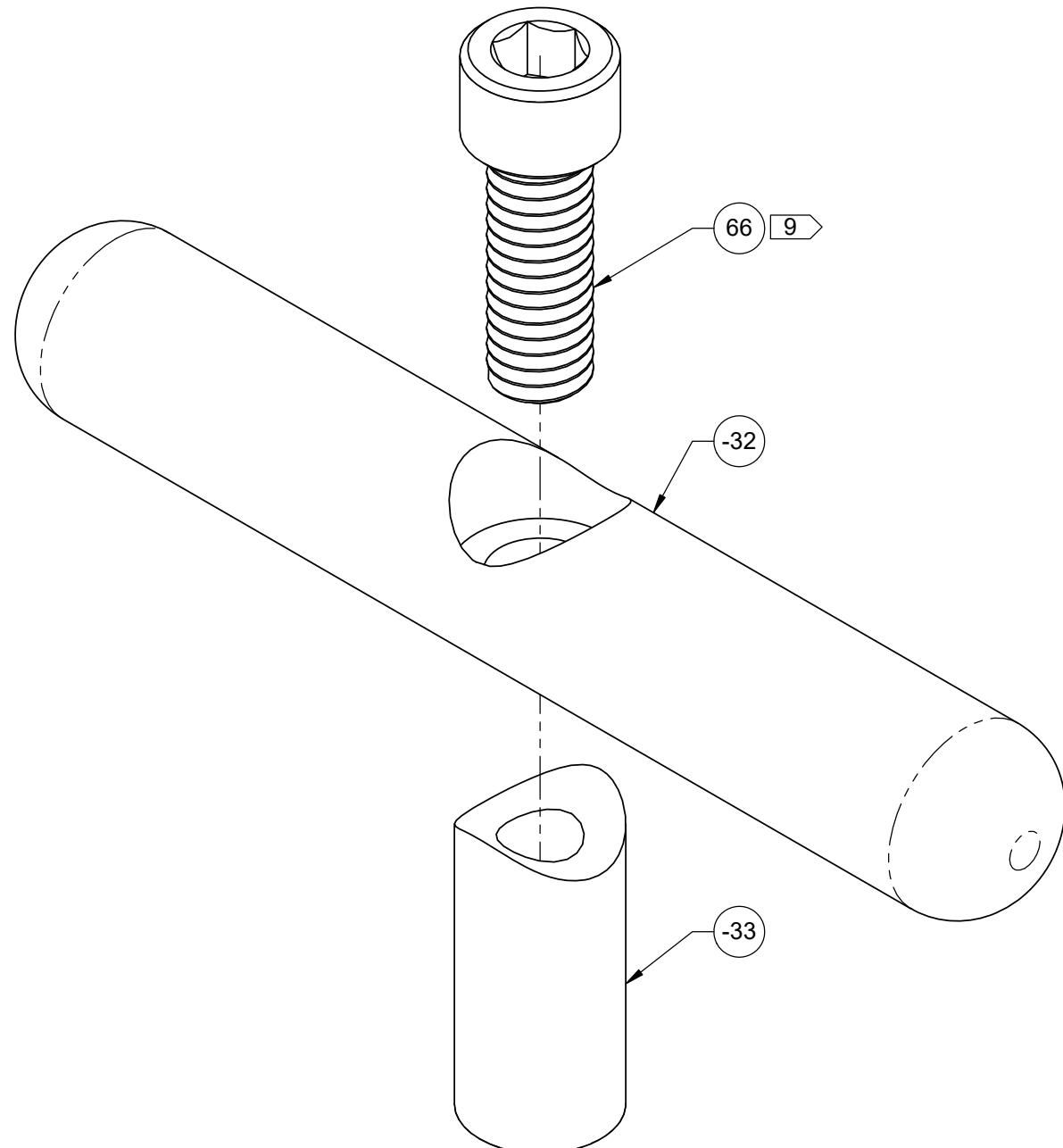
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RB 92700-10753-042-31 HANDLE ASSEMBLY

10

NOTES:

1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

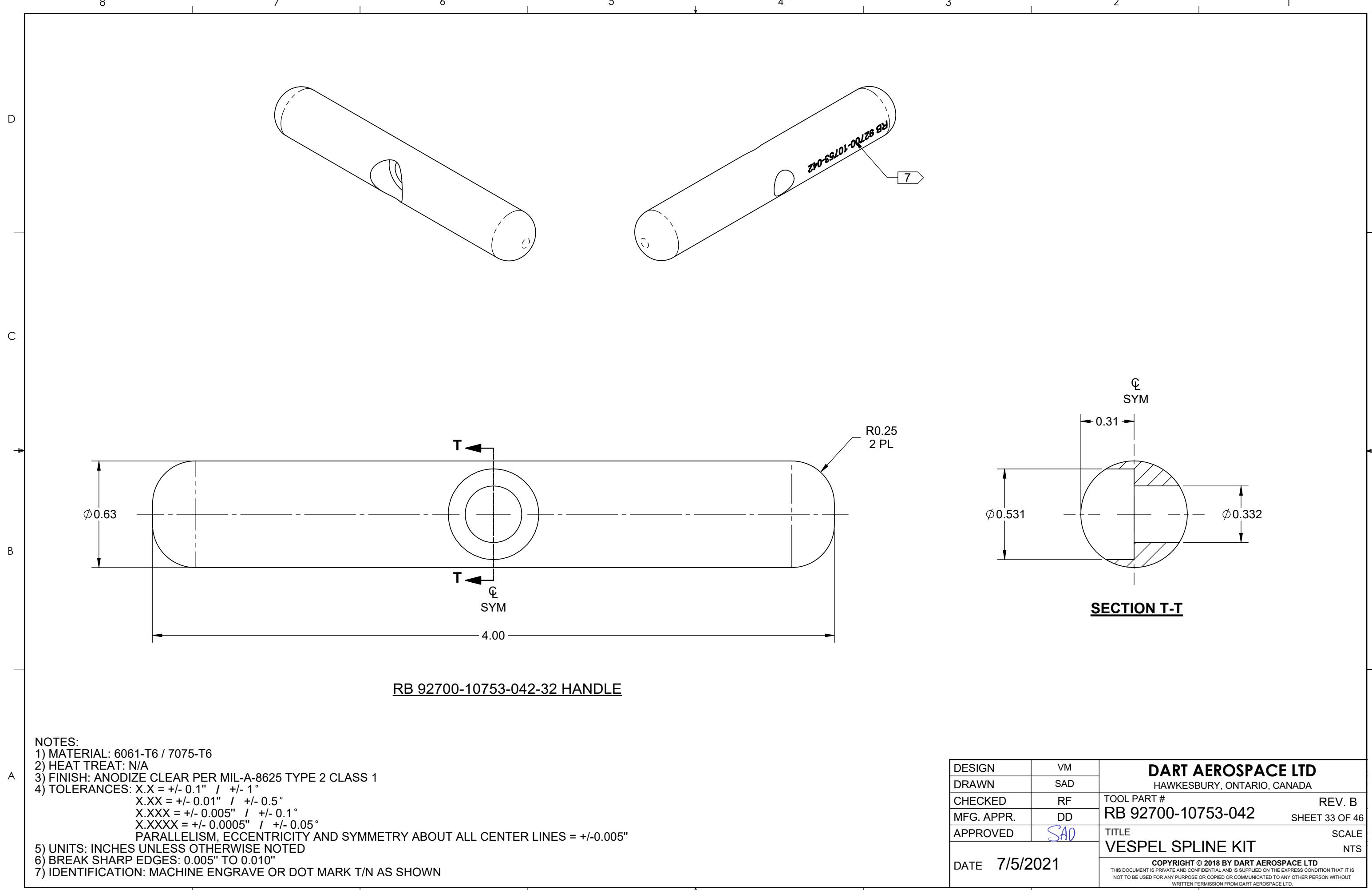
7) IDENTIFICATION: N/A

8) ASSEMBLE AS SHOWN

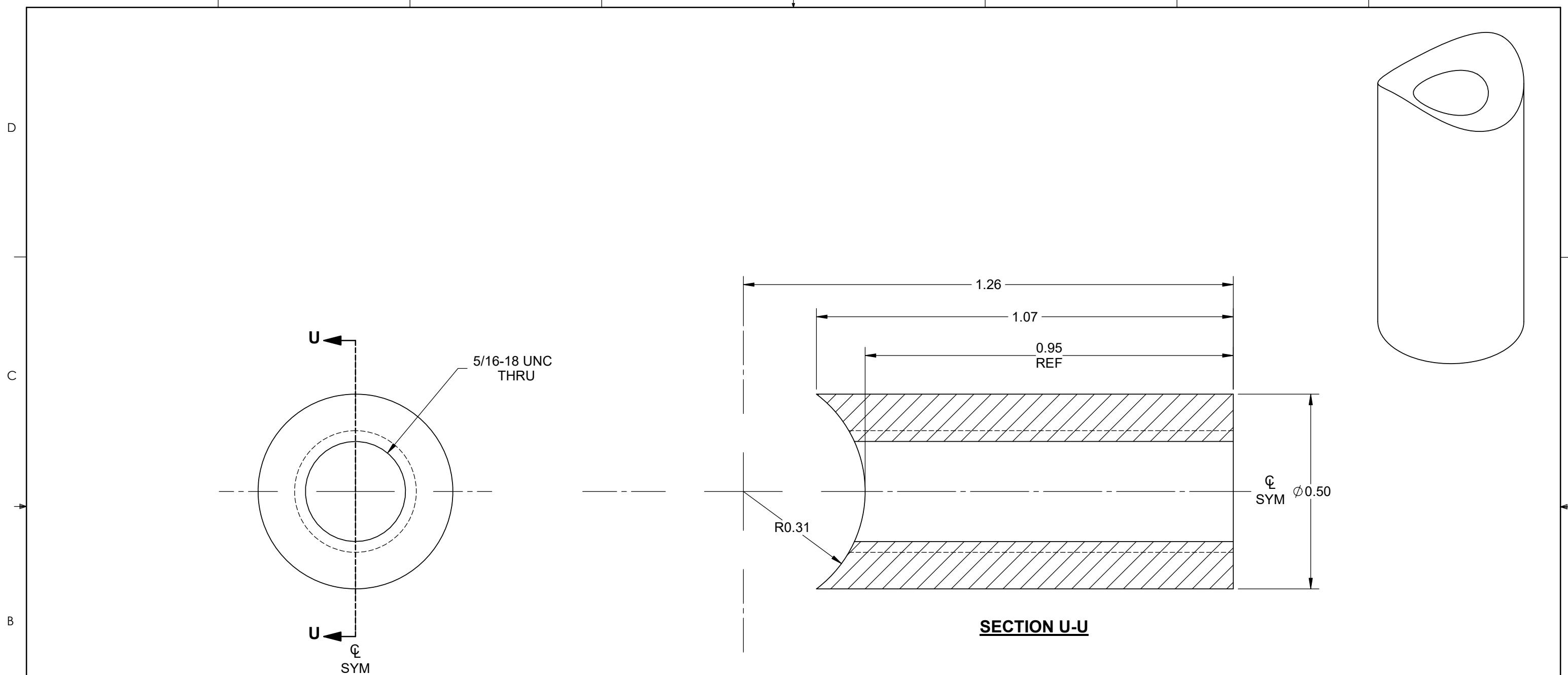
9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 66 THEN ASSEMBLE WITH ITEM -33 HAND TIGHT AND REMOVE EXCESS

10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	TOOL PART #
MFG. APPR.	DD	REV. B
APPROVED	SAD	RB 92700-10753-042
		SHEET 32 OF 46
DATE	7/5/2021	TITLE
		VESPEL SPLINE KIT
		SCALE
		NTS
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8 7 6 5 4 3 2 1



RB 92700-10753-042-33 PIN

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

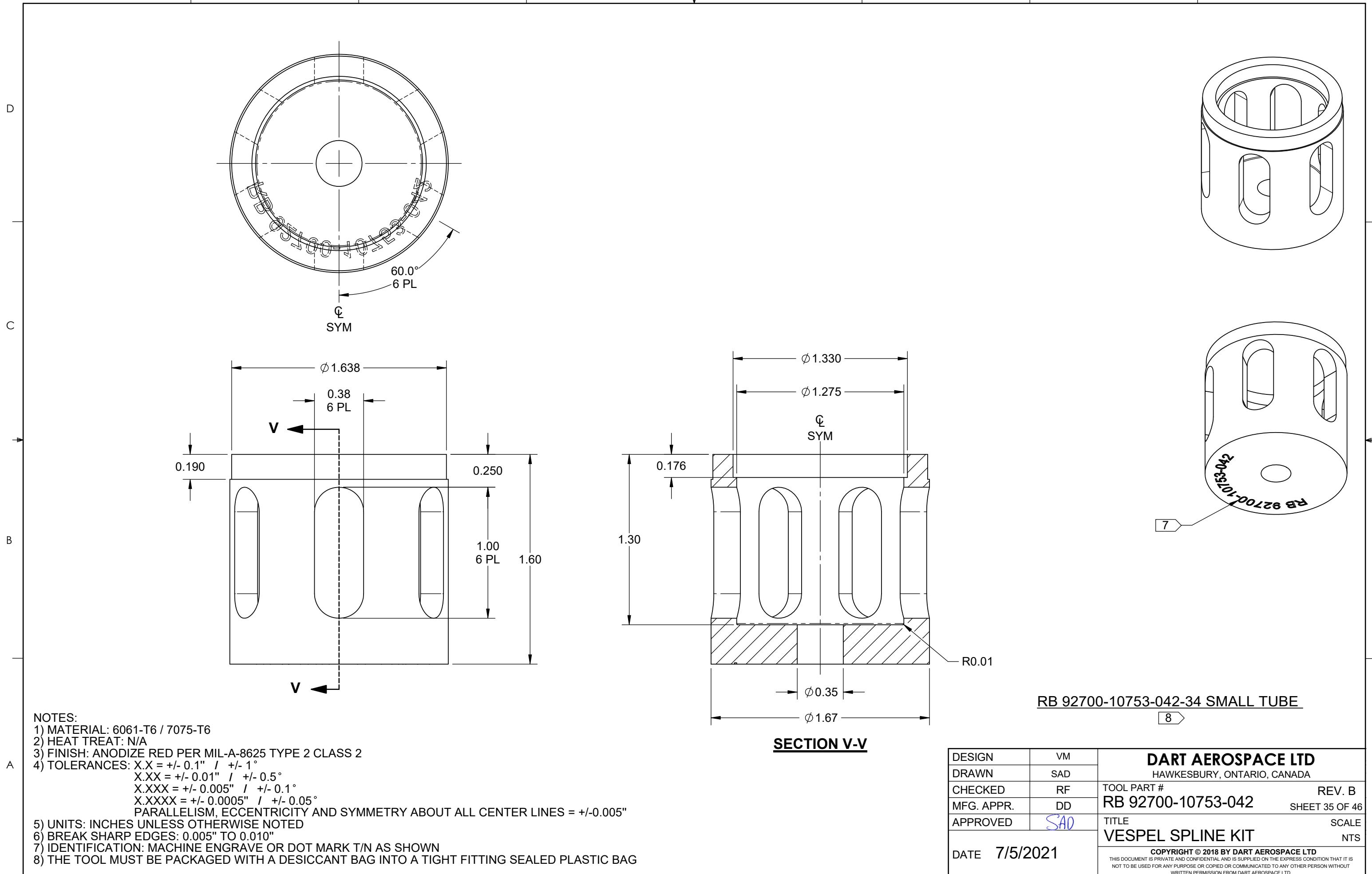
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

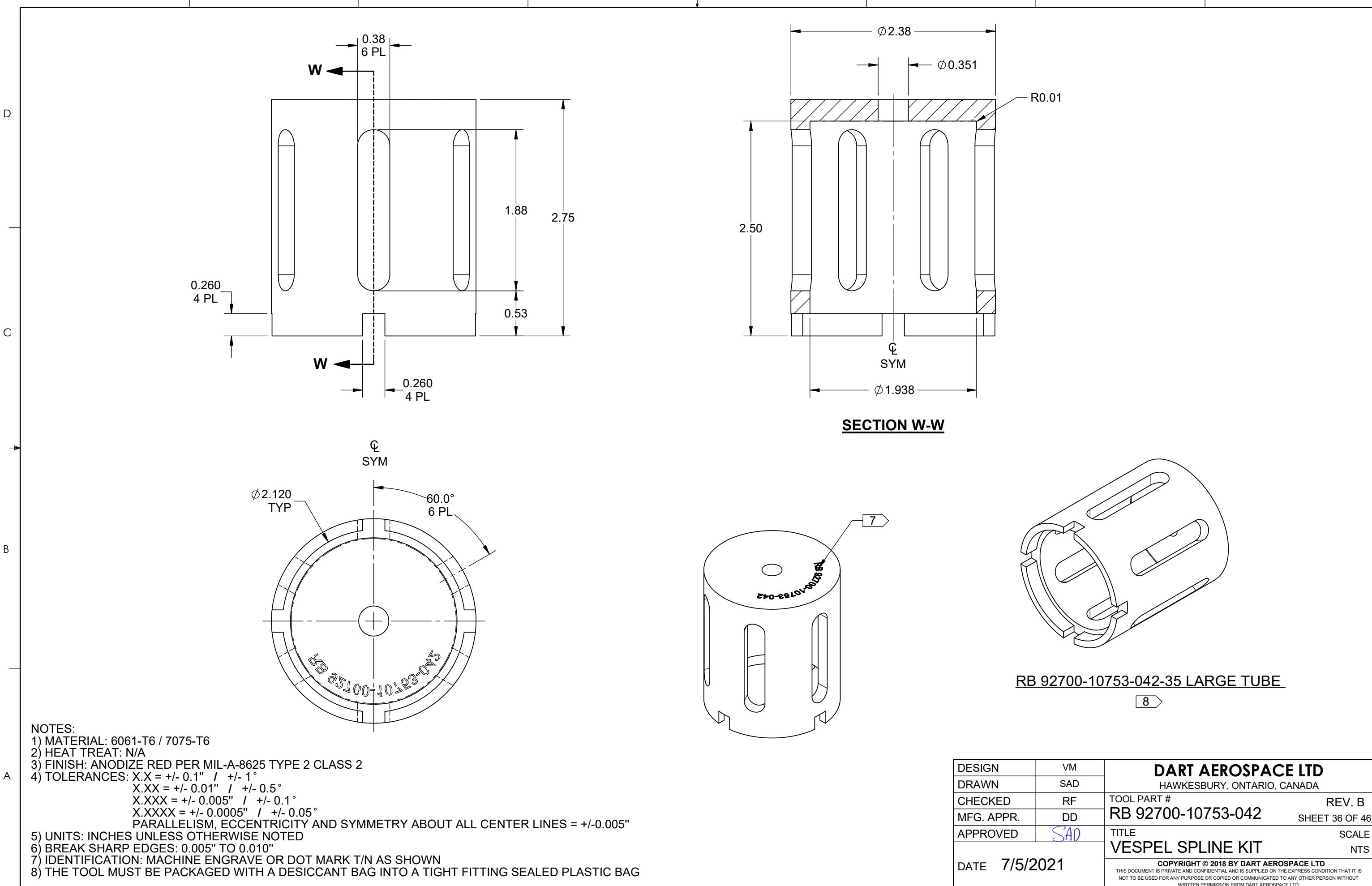
7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	TOOL PART #
MFG. APPR.	DD	REV. B
APPROVED	SAD	RB 92700-10753-042
		SHEET 34 OF 46
		TITLE
		VESPEL SPLINE KIT
		SCALE
		NTS
DATE	7/5/2021	COPYRIGHT © 2018 BY DART AEROSPACE LTD
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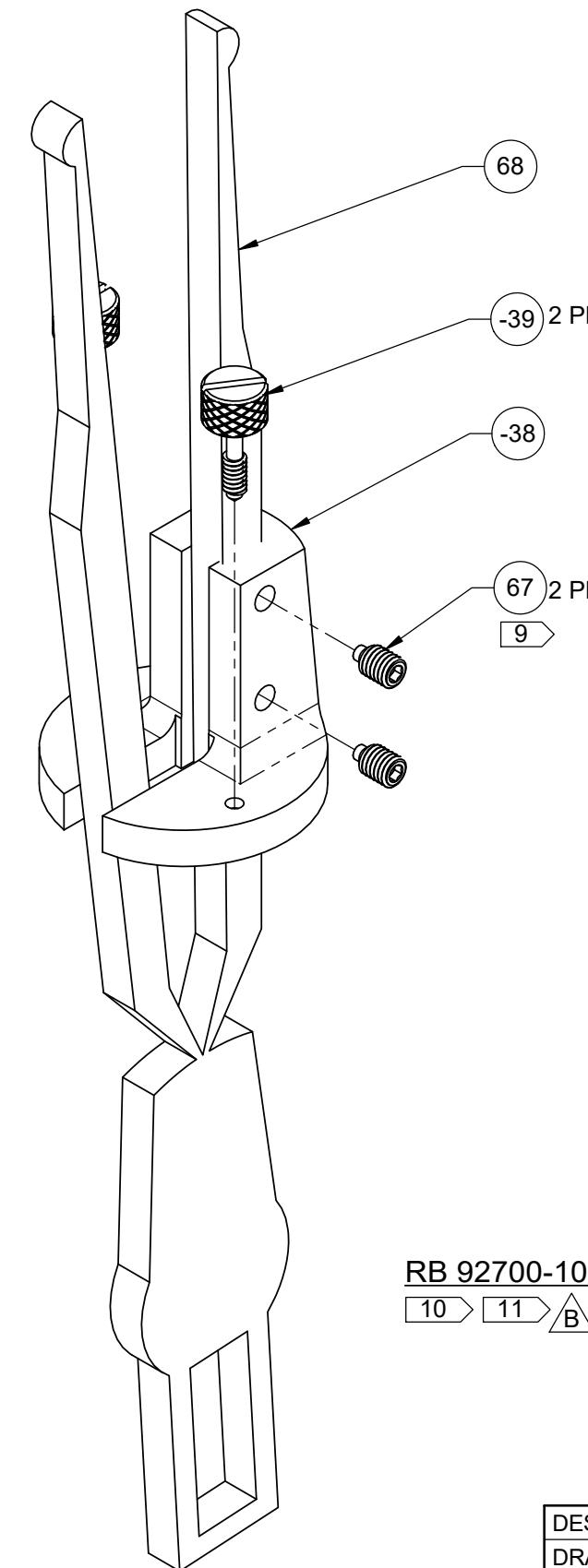
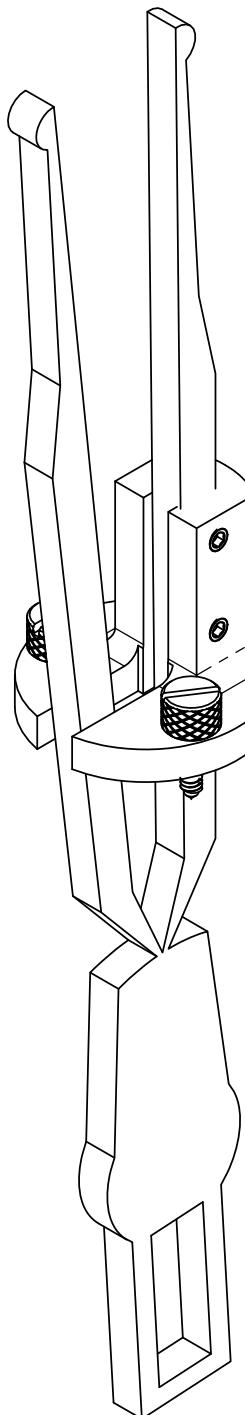


8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-38	1	RB 92700-10753-042-37	BLOCK
-39	2	RB 92700-10753-042-38	THUMB SCREW MODIFIED
67	2	McMaster#90291A825 OR EQUIV	SS NYLON TIP SET SCREW #10-32 x 1/4" LG.
68	1	DYER#101-105-16525	CUSTOM MADE MICROMETER



RB 92700-10753-042-36 GAGE ASSEMBLY

10 11 B

NOTES:

1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: N/A

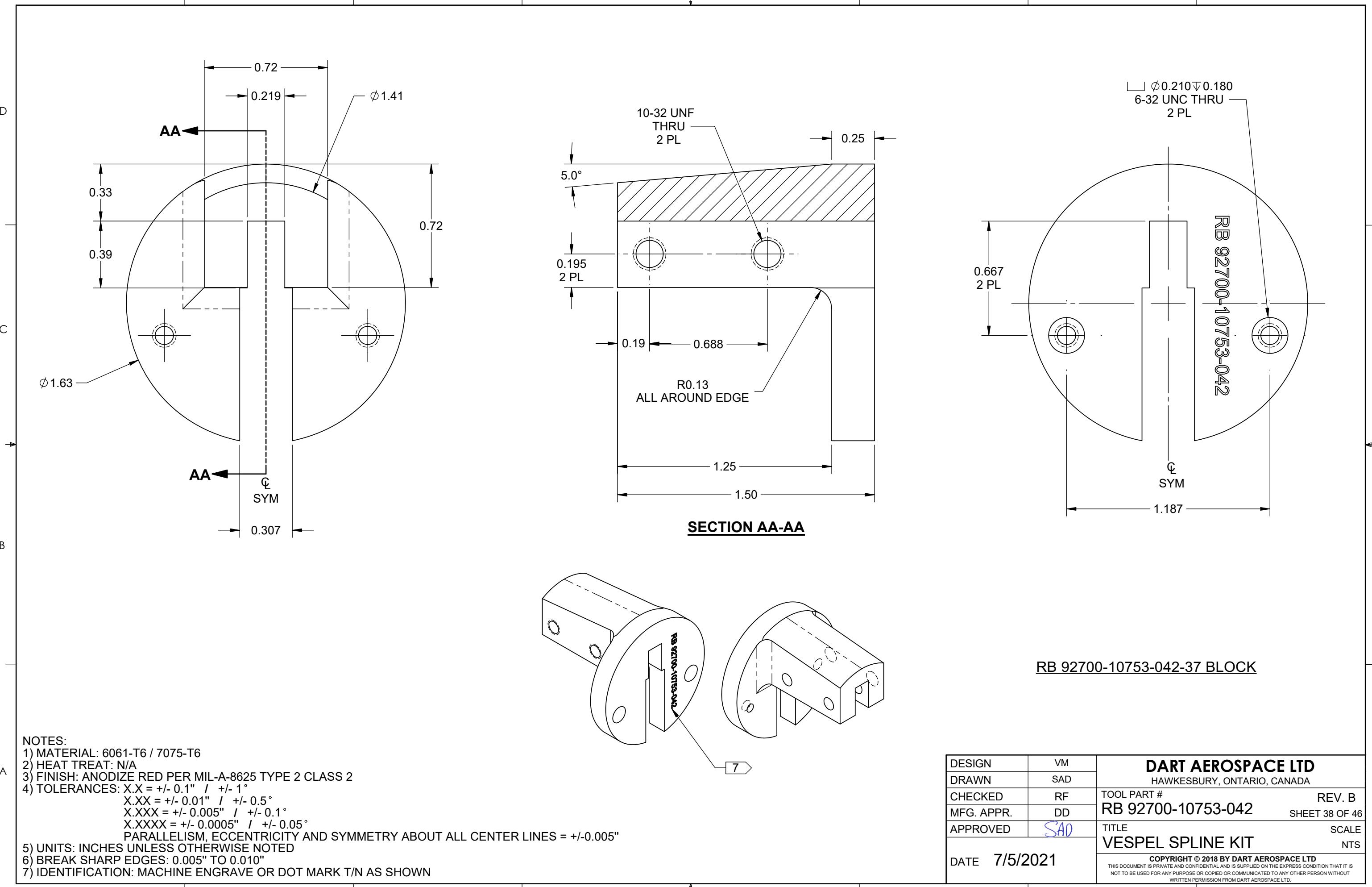
8) ASSEMBLE AS SHOWN

9) INSTALL ITEMS 67 HAND TIGHT

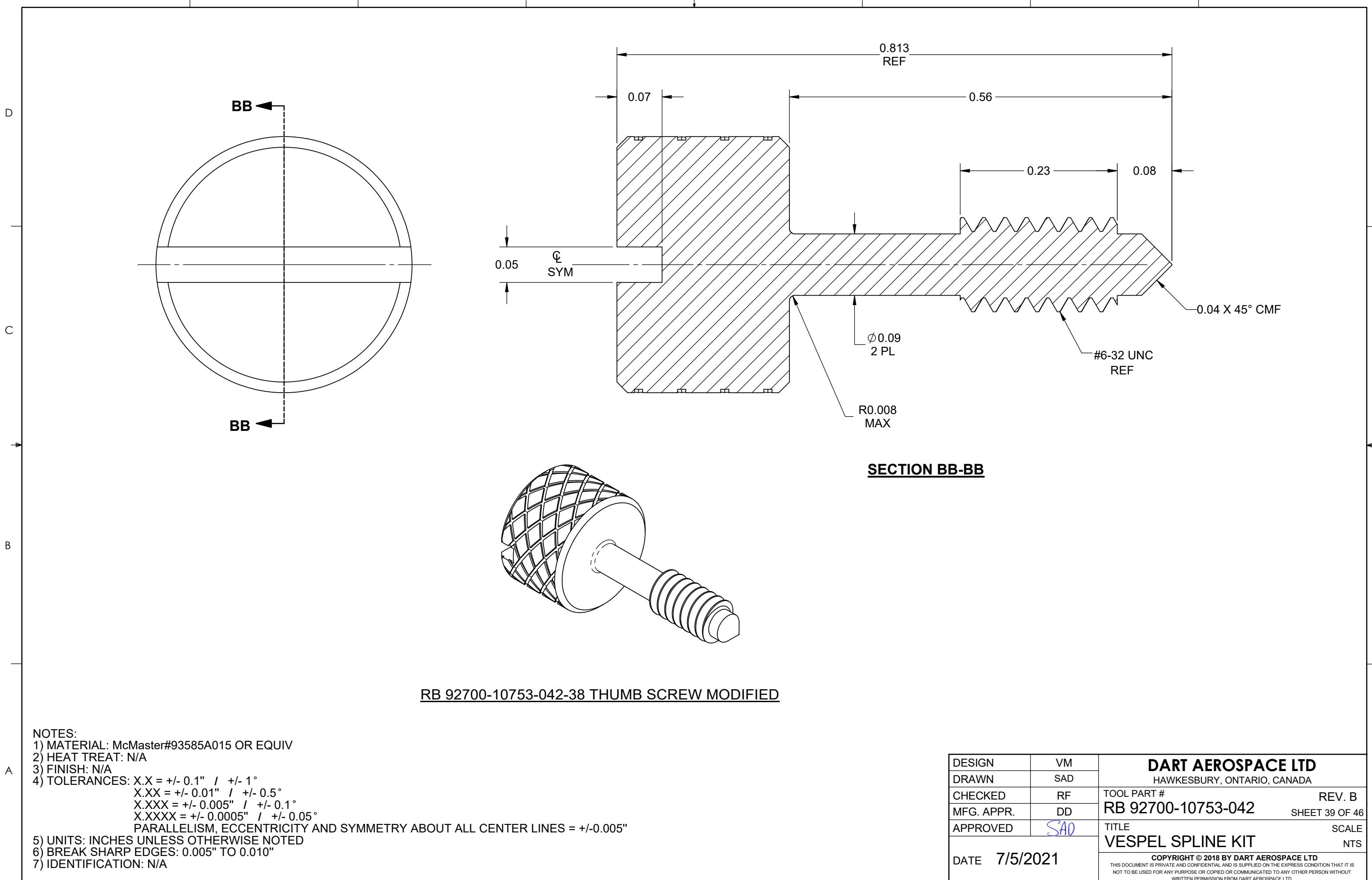
10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

△ B 11) ITEM ON DRAWING MAY NOT RESEMBLE PURCHASE PART

DESIGN	VM	DART AEROSPACE LTD			
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA			
CHECKED	RF	TOOL PART #			
MFG. APPR.	DD	REV. B			
APPROVED	SAD	RB 92700-10753-042			
DATE 7/5/2021		SHEET 37 OF 46			
TITLE VESPEL SPLINE KIT		SCALE NTS			
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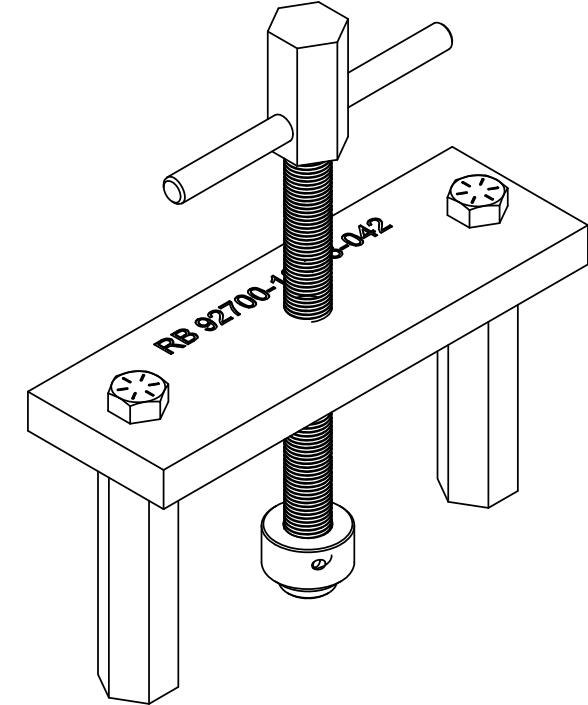
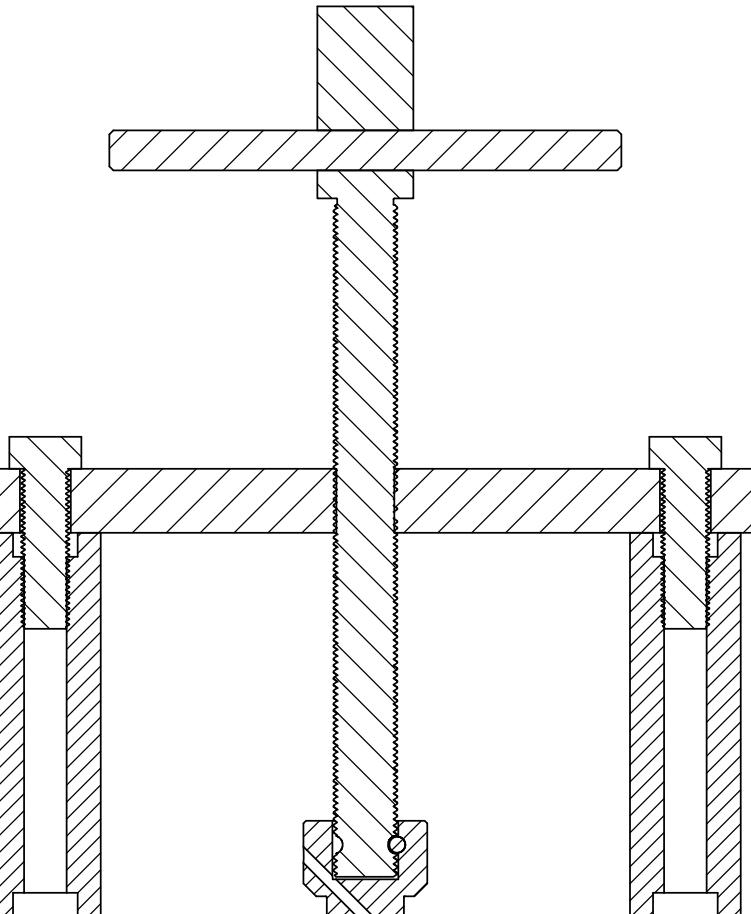
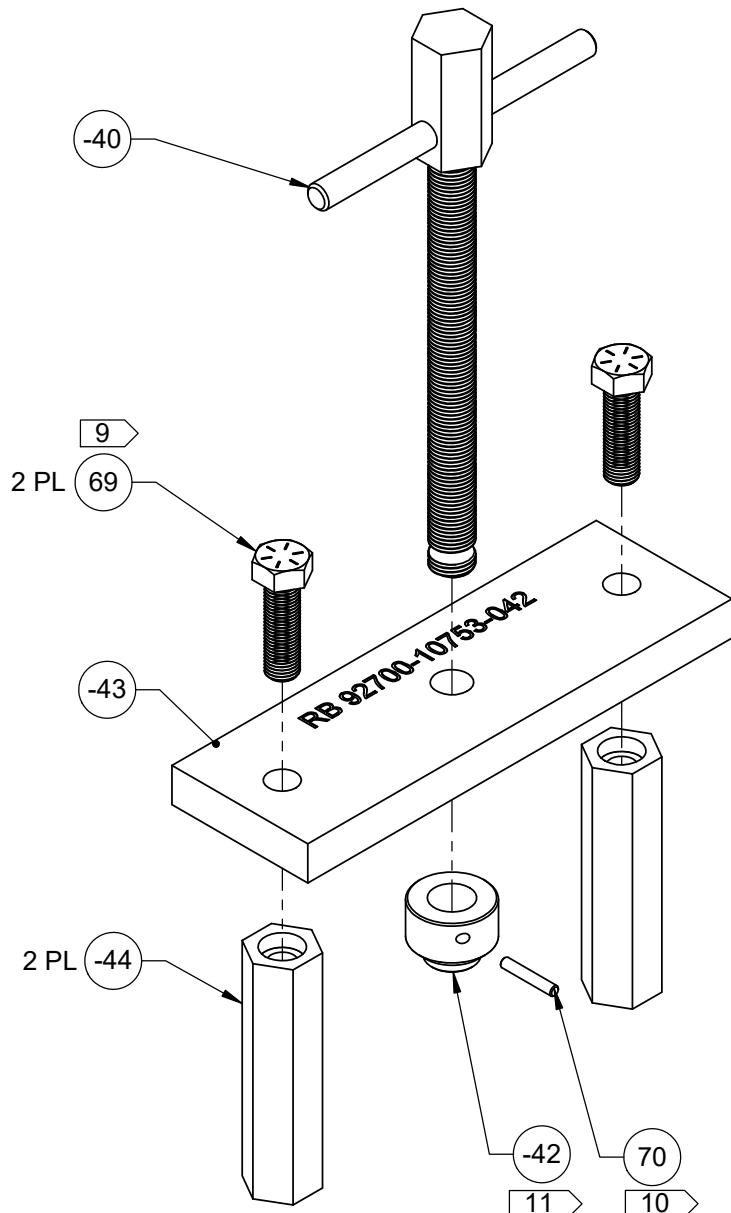
8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-40	1	RB 92700-10753-042-40	HANDLE ASSY
-42	1	RB 92700-10753-042-42	PUSHER
-43	1	RB 92700-10753-042-43	BASE
-44	2	RB 92700-10753-042-44	LEG
69	2	McMaster#92620A656 OR EQUIV	STEEL HEX HEAD SCREW 3/8"-24 x 1-1/4" LG.
70	1	McMaster#98381A308 OR EQUIV.	BLACK OXIDE ALLOY STEEL DOWEL PIN 1/8" DIA. X 3/4" LG.

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NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN
- 9) INSTALL ITEMS 69 HAND TIGHT
- 10) PRESS FIT ITEM 70 WITH ITEM -42
- 11) ITEM -42 MUST ROTATE FREELY
- 12) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

RB 92700-10753-042-39 APU SPLINE INSTALL TOOL

12

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	SAD	
CHECKED	RF	
MFG. APPR.	DD	
APPROVED	SAD	
TOOL PART #	REV. B	
RB 92700-10753-042		
	SHEET 40 OF 46	
TITLE	SCALE	
VESPEL SPLINE KIT	NTS	
DATE 7/5/2021	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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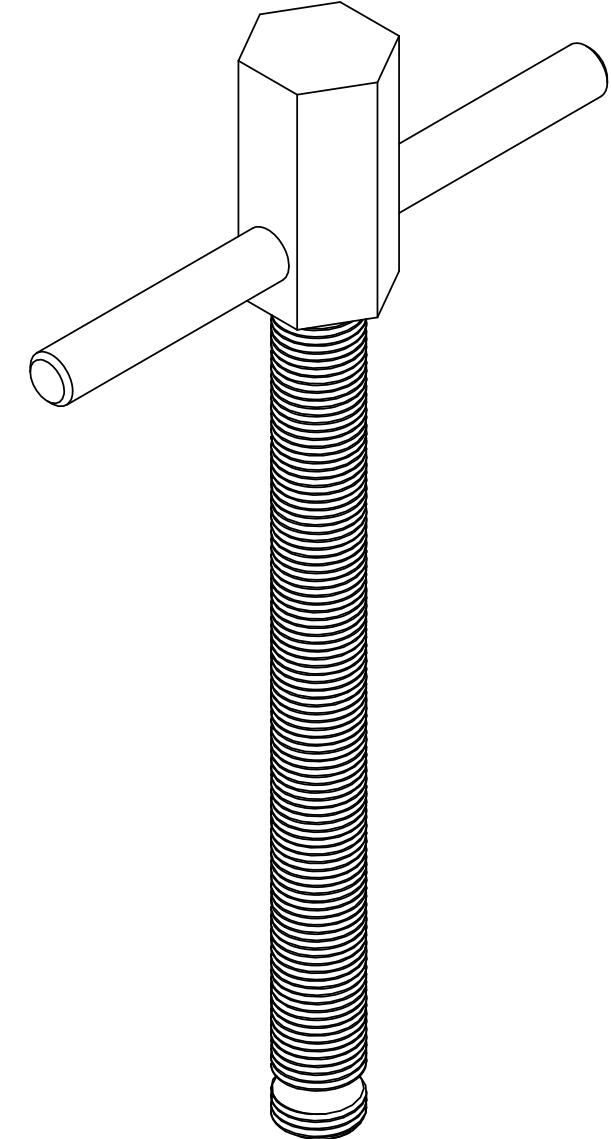
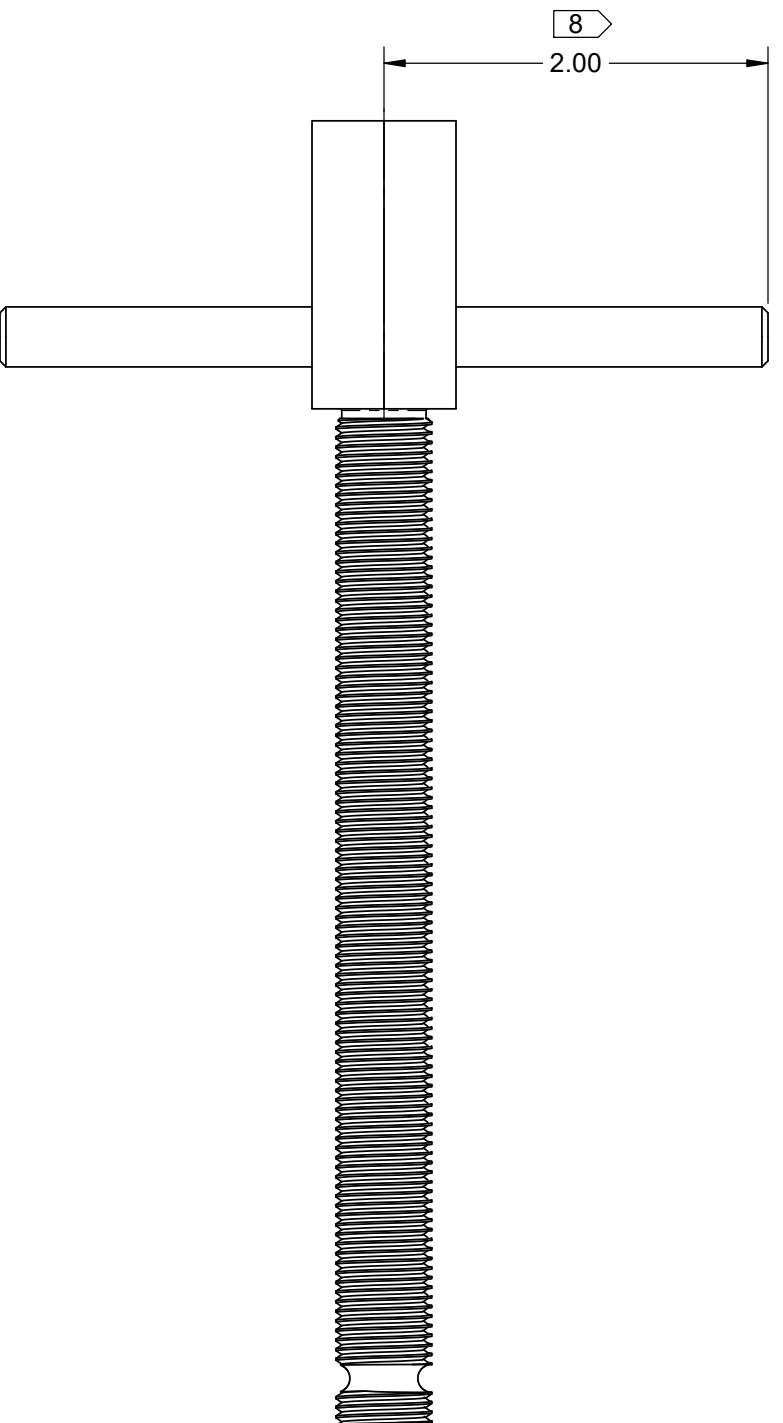
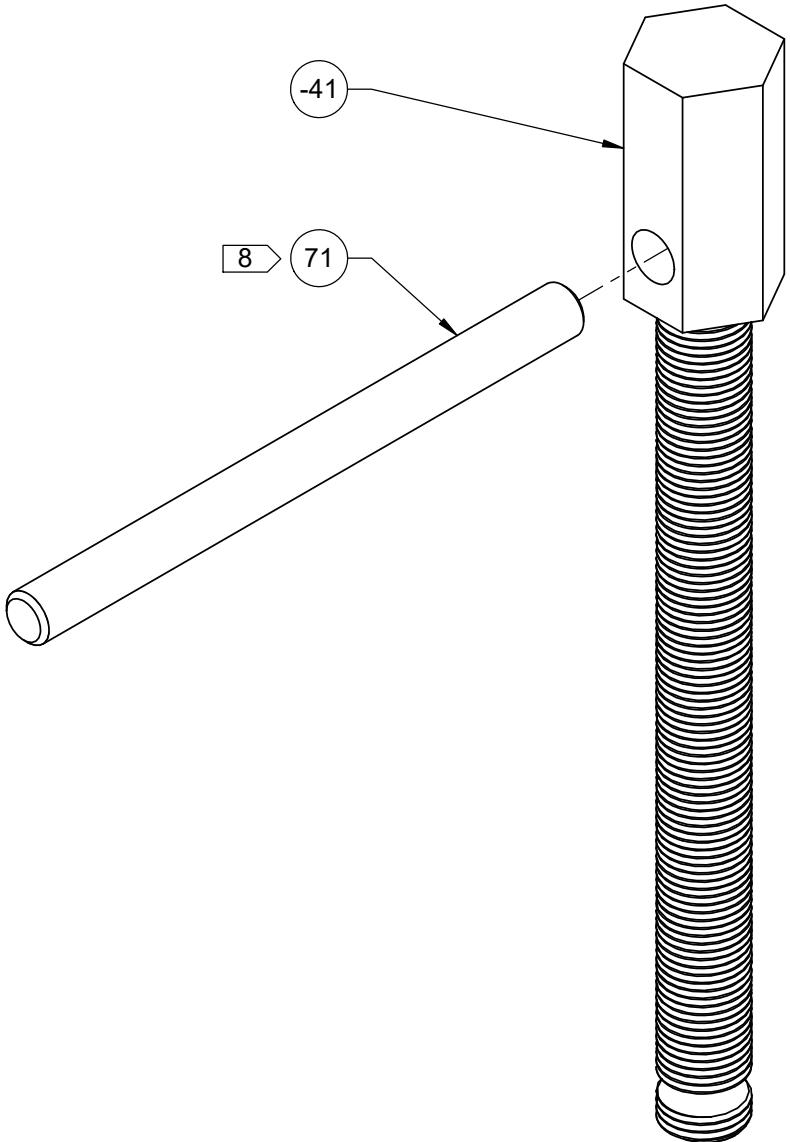
8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-41	1	RB 92700-10753-042-41	PIN
71	1	McMaster#98381A599 OR EQUIV	STEEL DOWEL PIN 5/16" DIA. x 4" LG.

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RB 92700-10753-042-40 HANDLE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

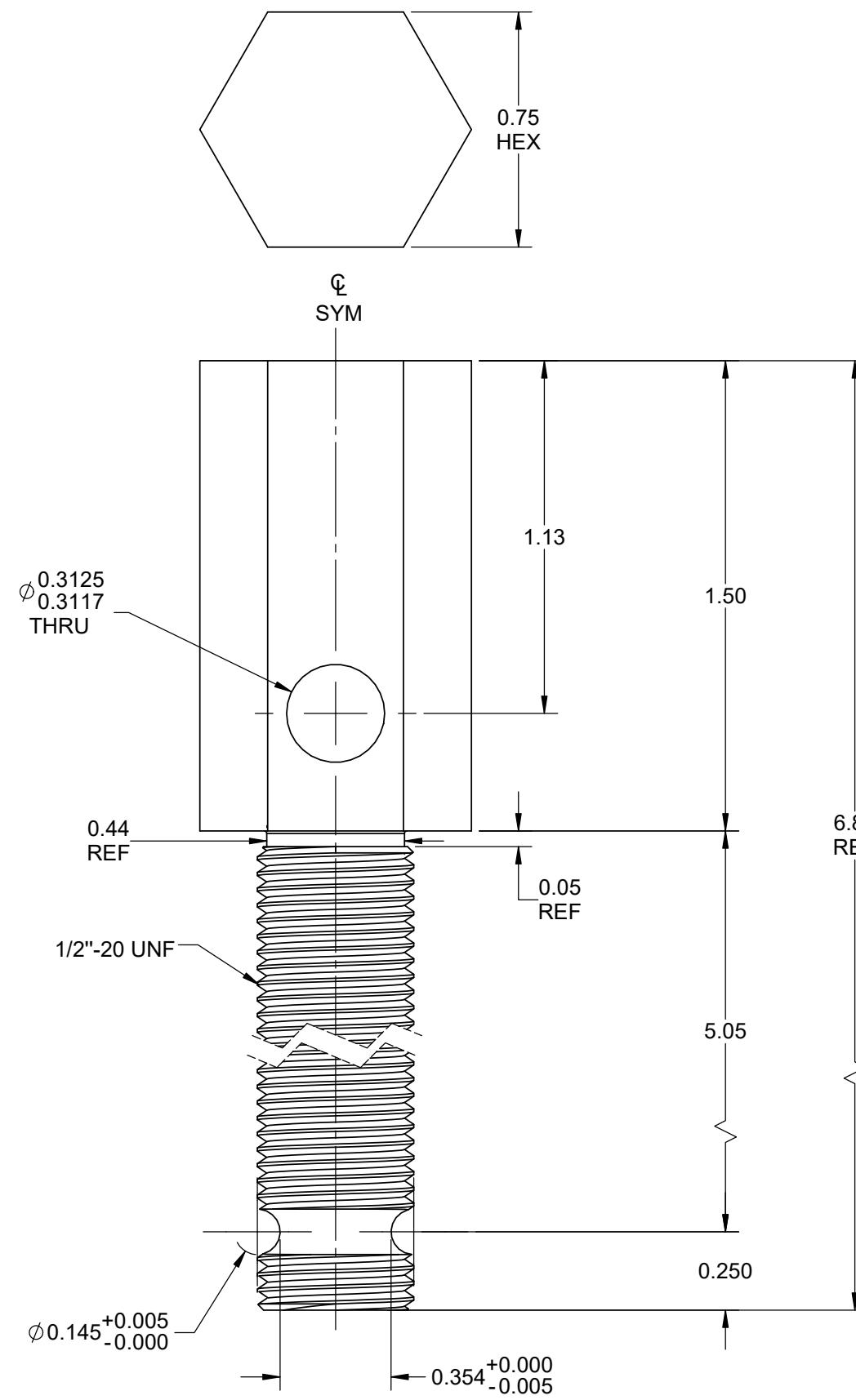
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

8) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 71 CENTERED WITH ITEM -41 AS SHOWN AND REMOVE EXCESS

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	SAD	
CHECKED	RF	
MFG. APPR.	DD	
APPROVED	SAD	
DATE	7/5/2021	
TOOL PART #	RB 92700-10753-042	REV. B
TITLE	VESPEL SPLINE KIT	NTS
SCALE		1
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NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY

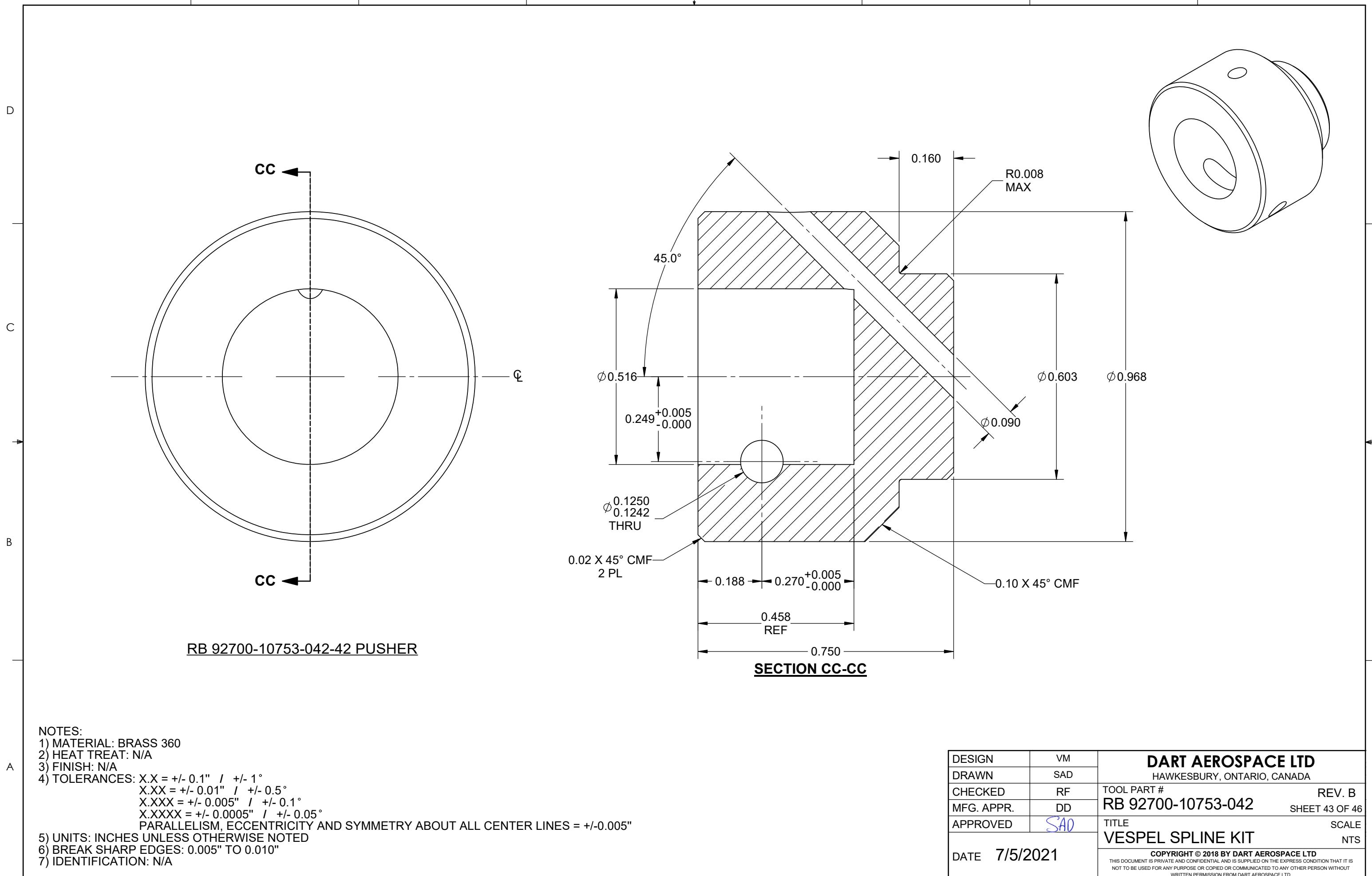
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAKAWAY EDGES 0.005" TO 0.010"

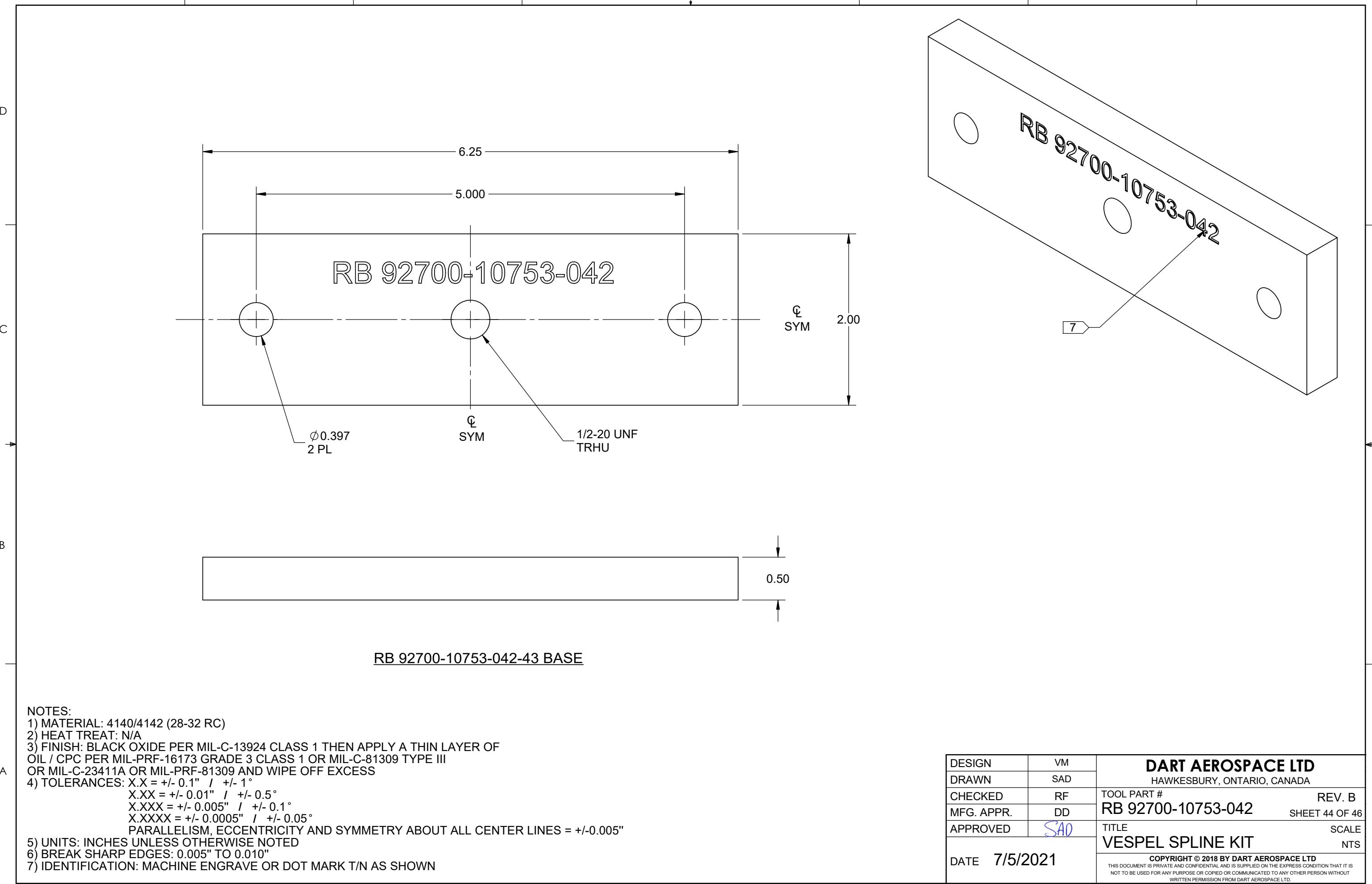
**6) BREAK SHARP EDGE
7) IDENTIFICATION: N/A**

RB 92700-10753-042-41 PIN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	RF	TOOL PART #	REV. B
MFG. APPR.	DD	RB 92700-10753-042	SHEET 42 OF 46
APPROVED	<i>SAD</i>	TITLE VESPEL SPLINE KIT	SCALE NTS
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8 7 6 5 4 3 2 1

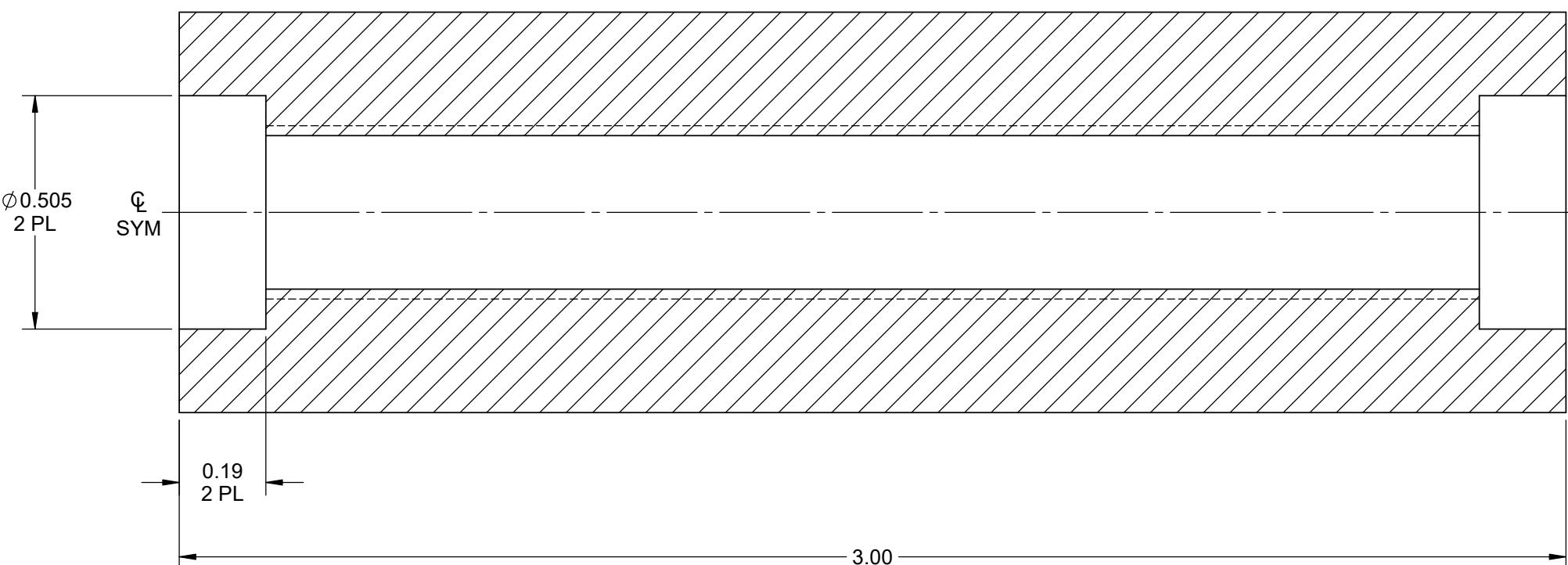
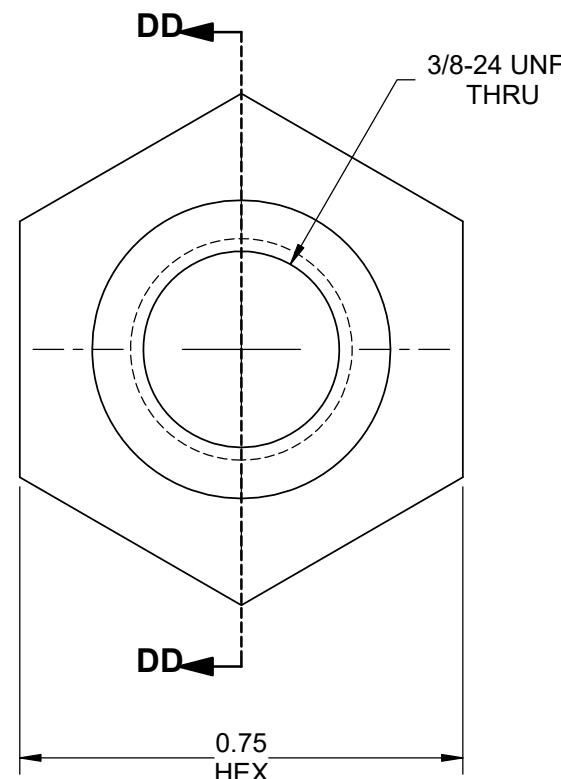




8 7 6 5 4 3 2 1

D

D



SECTION DD-DD

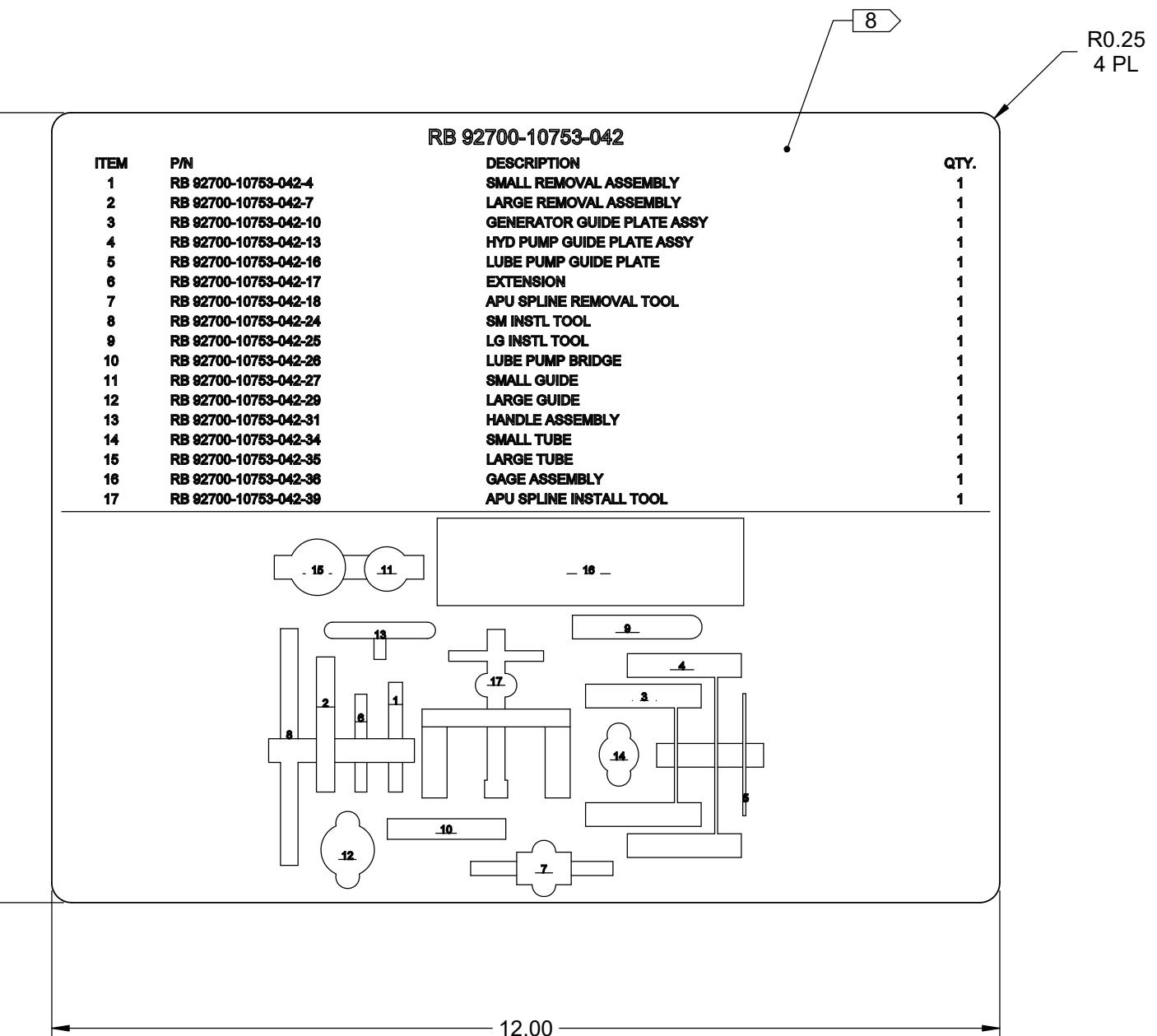
RB 92700-10753-042-44 LEG

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	REV. B	
MFG. APPR.	DD	TOOL PART # RB 92700-10753-042	
APPROVED	SAD	SHEET 45 OF 46	
DATE 7/5/2021		TITLE VESPEL SPLINE KIT	SCALE NTS
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RB 92700-10753-042-45 POSITION PLACARD

NOTES:

- 1) MATERIAL: MULTI-CRAFT PLASTICS # LM922402 OR EQUIV
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) BLACK BACKGROUND WITH WHITE LETTERS AND LINES

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	RF	TOOL PART #	REV. B
MFG. APPR.	DD	RB 92700-10753-042	SHEET 46 OF 46
APPROVED	SAD	TITLE	SCALE
		VESPEL SPLINE KIT	NTS
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